

INSTRUCTION MANUAL  
AND  
ILLUSTRATED PARTS LIST

FOR

**SINGER**

MACHINES

1371A1

1371A2

1371A3

THE SINGER COMPANY



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# 使用说明

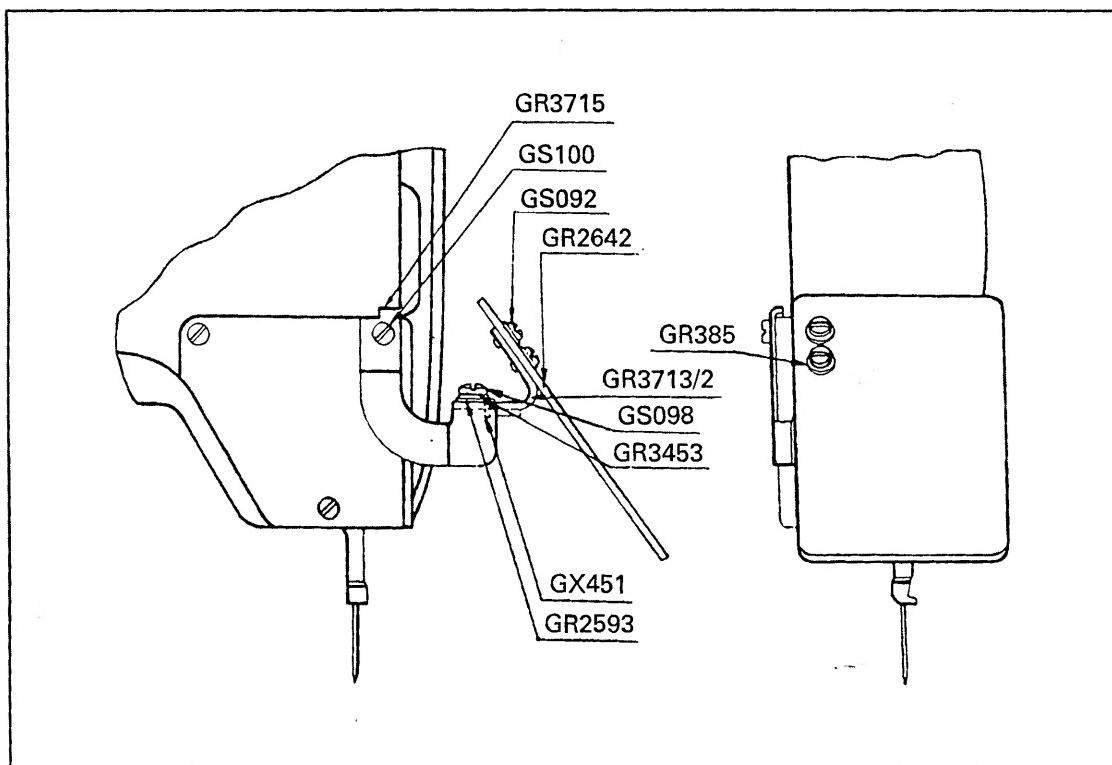
## INSTRUCTION MANUAL

## ① 防护板安装说明书 HOW TO INSTALL THE SAFETY PLATE

a. 在图示位置, 用防护板支架安装固定螺丝, 安装该块防护板。

如图所示安装安全板部件, 通过左侧盖板螺钉固定安全板部件。

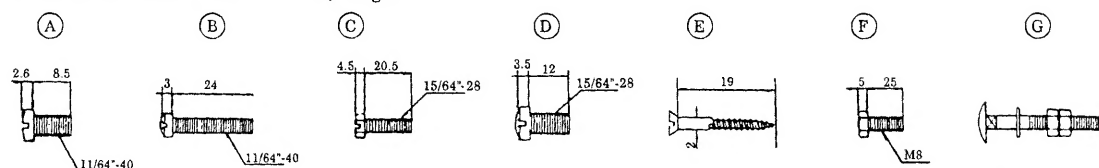
Install the safety plate at the position shown in the figure by means of safety plate installing bracket set screw.



## ② 安装说明 INSTRUCTION FOR SET UP

1. 用于安装的螺钉：参看图示 图a

1. Screws used for set up Fig.a



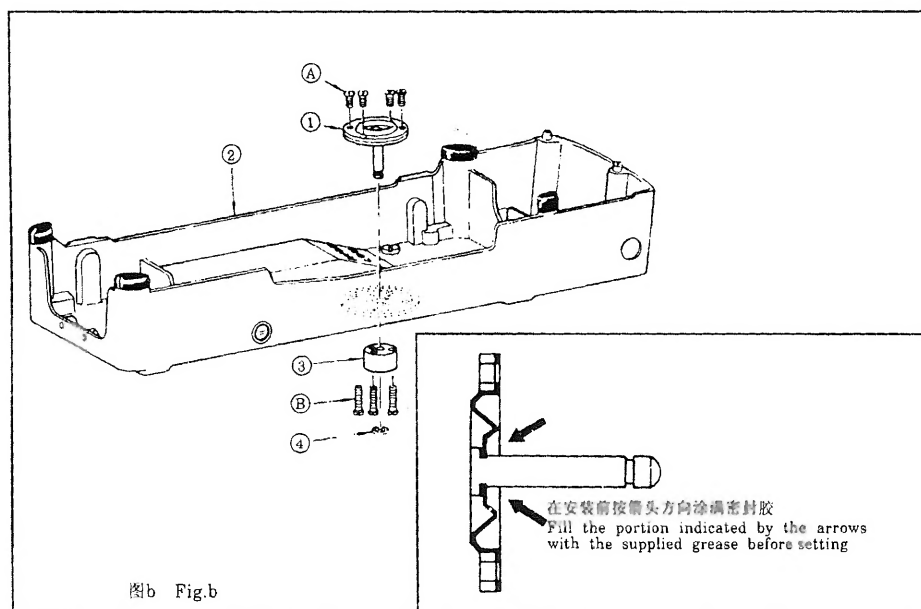
图a Fig.a

2. 变速拨叉顶杆部件的安装：

- 1) 在变速拨叉顶杆部件①上涂满已提供的润滑油脂，背面的橡胶表面也要涂。参看图示 图b
- 2) 用螺钉 ①A，将变速拨叉顶杆部件固定在机壳底座②上。
- 3) 用螺钉 ①B，将拨叉顶杆座③固定在机壳底座②的背面，以便使变速拨叉顶杆部件能上、下运动灵活。
- 4) 将档圈④装于拨叉顶杆上。

### 2. Attaching the shifter driving pin (asm.)

- 1) Fully apply the supplied grease to the pin of the shifter drive pin (asm.)① and the rubber surface on the rear see Figure Fig.b
- 2) Using screw ①A, fix the shifter driving pin (asm.) on machine head base ②.
- 3) Using screw ①B, fix driving pin base ③ on the rear surface of the machine head base so that the shifter driving pin moved up and down smoothly.
- 4) Install snap ring ④on the shifter driving pin (asm.).



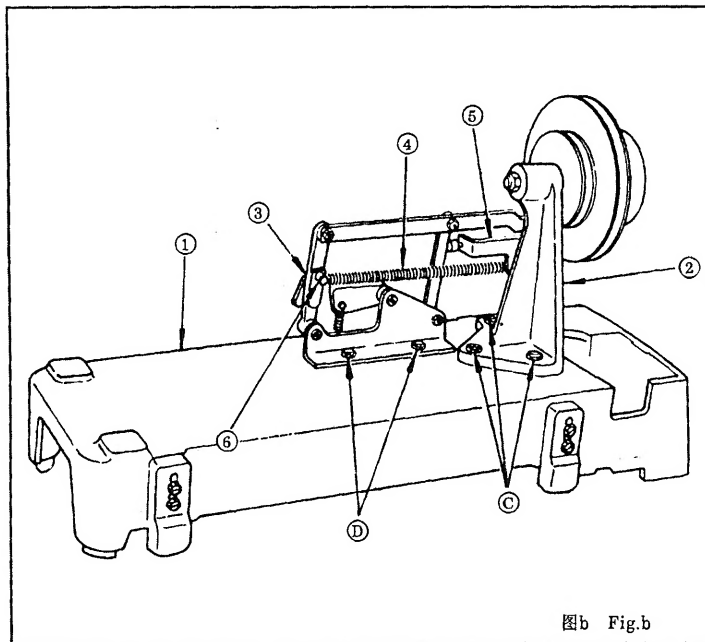
图b Fig.b

### 3. 变速皮带轮部件和变速拨叉部件的安装: 图c

- 1) 机壳底座①的位置方向应使其背面正对操作者。
- 2) 用螺钉 ③ 固定变速皮带轮部件②。
- 3) 用螺钉 ④ 固定变速拨叉部件③。
- 4) 将拨叉拉簧④固定在变速拨叉限位架和拨叉拉簧螺钉⑥上。

### 3 Installing transmitter (asm.) and shifter base (asm.) Fig.c

- 1) Place machine head base ① with its rear surface facing toward you.
- 2) Fix transmitter (asm.) ② by screw ③
- 3) Fix shifter base ③ by screw ④
- 4) Attach shifter tension spring ④ to shifter stopper bracket (asm.) ⑤ and shifter tension spring bracket ⑥ of the shifter stopper base (asm.).

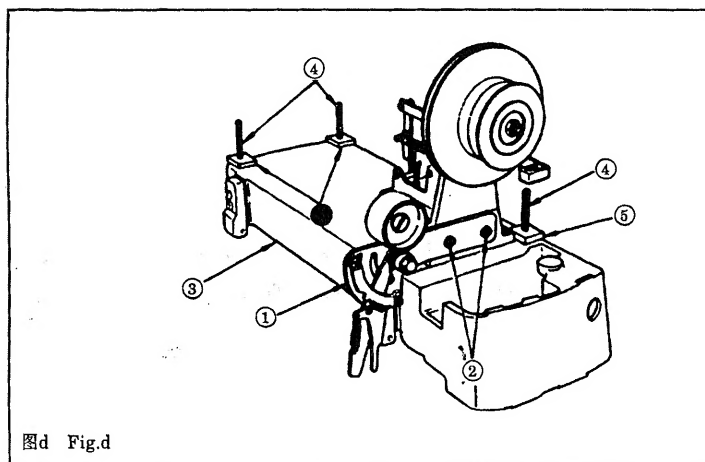


### 4. 固定压紧轮座 图d

- 1) 用压紧轮座螺钉②固定压紧轮座①。
- 2) 将机壳底座螺钉④和机壳底座垫⑤安装在壳底座③上。
- 3) 再次对变速拨叉顶杆部件进行润滑。顶杆的端部和拨叉顶杆座固定螺钉的头部也须进行润滑。

### 4. Supplied with the reducer (asm) Fig.d

- 1) Fix tension pulley coupling ① by hexagon screw ② supplied with the reducer (asm.).
- 2) Install stud ④ and machine head base seat felt ⑤ on machine head ③.
- 3) Fully lubricate the shifter driving pin and the driving pin base again. Also lubricate the end of the shifter driving pin and the head of the screw of the shifter pin bracket.

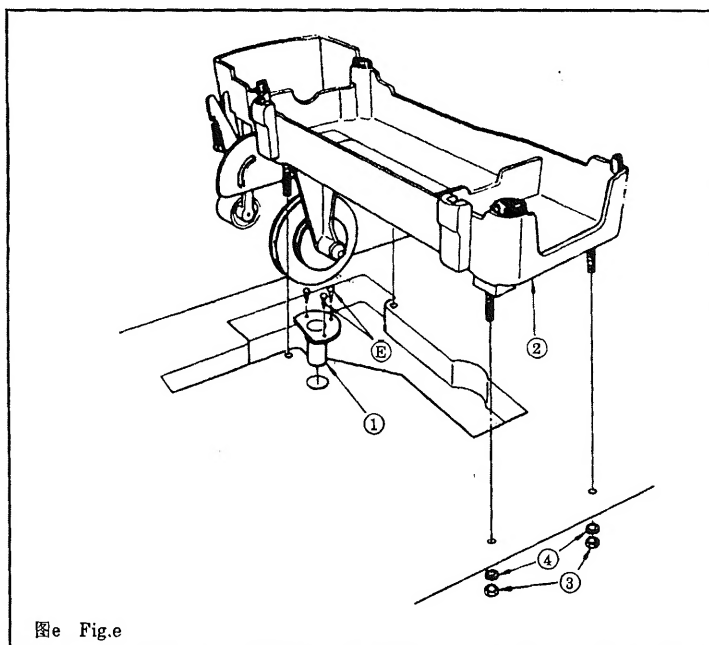


#### 5. 机壳底座座组件的安装:图e

- 1) 用木螺钉 ⑤, 将排油漏斗①固定在位于工作台内的直径为  $\phi 25$  的排放孔口上。
- 2) 先将机壳底座组件放在工作台上, 然后拧紧螺母③和垫圈④, 自工作台底部, 固定该机壳底座组件。

#### 5. Installing the machine head base (asm.) Fig.e

- 1) Fix drain funnel ① to the drain hole ( $\phi 25$ ) in the table by wood screw ⑤.
- 2) Placing the machine head base (asm.) on the table, fix it by tightening nut ③ (flat washer ④ is used) from the bottom of the table.



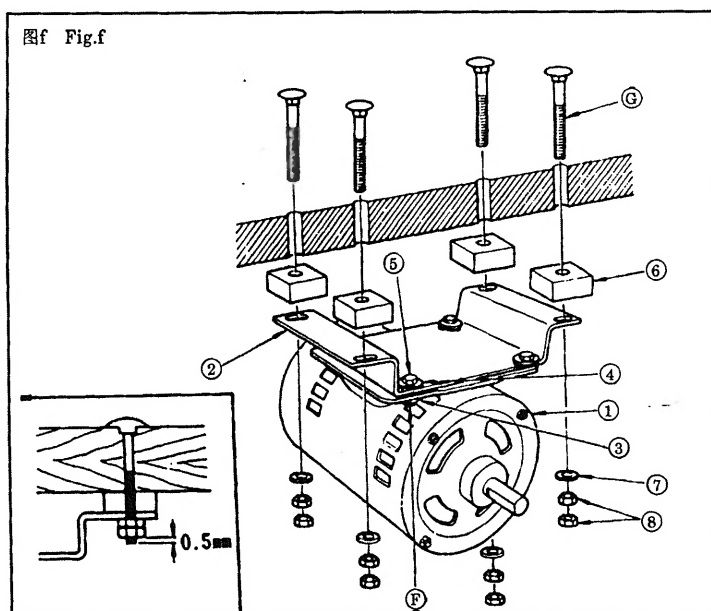


## 6. 电机的安装: 图f

- 1) 用螺钉 ⑤, 垫圈③, 弹簧垫圈④和螺母⑥, 将马达①安装于电机安装座②上。
- 2) 先在工作台底部电机座之间放置隔距垫块, 然后用安装螺栓 ⑥, 垫圈⑦螺母⑧固定电机安装座, 拧紧螺母, 使螺栓 ⑥ 的端部与下方螺母齐平或使螺栓 ⑥ 在拧紧后的伸出距离为0.5mm(毫米)。(参看图示)。

## 6. Installing the motor Fig.f

- 1) Install motor ① on motor base ② by screw ⑤ (flat washer ③, spring washer ④, and nut ⑥ are used).
  - 2) Placing spacer ⑥ between the table bottom and the motor base, fix the motor base by installing bolt ⑥ (a flat washer ⑦ and nut ⑧ are used).
- Tighten the nuts so that the lower nut is levelled with the end of bolt ⑥ or bolt ⑥ projects by 0.5 mm.



## 注意事项

- 1)从操作者方向看,机器应顺时针方向转动,请不要让机器反转。
- 2)油盘内未加油绝不能开车。
- 3)试车前应将梭子,梭心和面线取下。
- 4)每天用车后,请清洁旋梭和剪底线刀处的废物,然后检查油盘里的油量。
- 5)机器运转期间,不能将手指或头发靠近上轮,V型皮带,绕线轮和电动机,也不要在此上面放任何东西,以免受损伤。
- 6)装拆皮带、防护罩和其它保护装置时,请勿开动机器。

## CAUTIONS IN OPERATION

- 1) The machine should rotate counterclockwise as observed from the pulley. Take care not to rotate the machine in the opposite direction.
- 2) Never start the machine before filling the machine base with lubricating oil.
- 3) Remove the bobbin case and the needle thread from the machine before performing the trial operation.
- 4) Clean up the sewing hook and the bobbin thread trimmer every day after sewing work. Also check the level of the lubricating oil.
- 5) Never bring your fingers or hair close to, or place anything on the handwheel, V-belt, bobbin winder wheel or motor during operation. It may lead to serious personal injuries.
- 6) If your machine is provided with a belt cover, finger guard and eye guard, never operate your machine with any of them removed.

### 1. 电动机带轮和V型皮带

### 1. MOTOR PULLEY AND V BELT

- 1)电机采用三相四极370W电机(如果用单相250W电机缝速不要超过2600转/分,订货时需说明)
- 2)选用M型V型皮带
- 3)电动机带轮, V型皮带和缝速列表如下:

缝速	频率	电动机带轮件号	V型皮带(高速)	V型皮带(低速)
2600转/分	50HZ	GD370	GE137	GE137
3000转/分	50HZ	GD370H	GE136	GE137
2600转/分	60HZ	GD370L	GE137L	GE137
3000转/分	60HZ	GD370HH	GE137H	GE137

- 1) Motors of 370w, 4-pole are used three-phase operation. (If a 250W motor has to be used for single-phase, operate the machine at 2600 s.p.m. or less. according to order form)
- 2) M-type V belts are used.
- 3) Refer to the following table for the motor pulleys, V belt, and sewing speed.

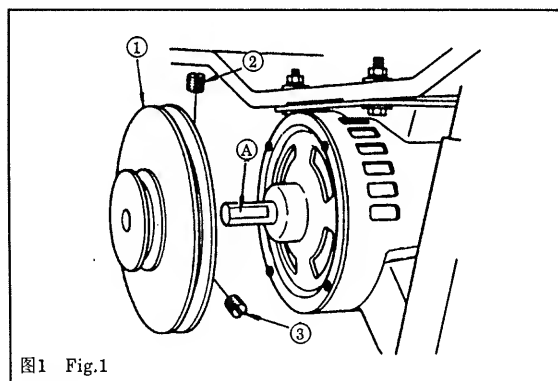
Sewing speed	Frequency	Motor pulley Part No.	High speed V belt	Low speed V belt
2600 s.p.m.	50HZ	GD370	GE137	GE137
3000 s.p.m.	50HZ	GD370H	GE136	GE137
2600 s.p.m.	60HZ	GD370L	GE137L	GE137
3000 s.p.m.	60HZ	GD370HH	GE137H	GE137

**\*电动机带轮的安装方法 图1**

将电机带轮①中的键槽 A 对准电机轴上键槽, 推足带轮, 然后旋紧紧定螺钉②和③。

**\* How to install motor pulley Fig.1**

Place motor pulley ① into the motor shaft so that flat part A of the motor shaft aligns with first setscrew ②. Then securely tighten setscrews ② and ③.



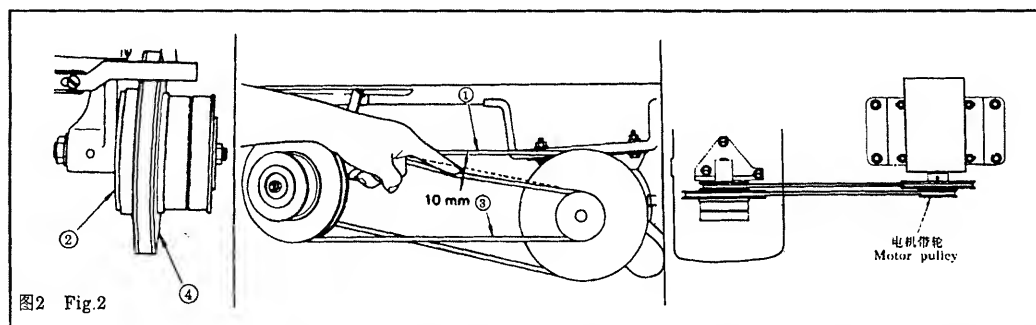
**\* V型皮带的安装方法 图2**

- 1)将高速V型皮带①装在增速皮带轮②和直径大的电机皮带轮上。
- 2)将低速V型皮带③装在低速皮带轮④和直径小的电机皮带轮上。
- 3)皮带①和③的松紧度以手指轻压皮带中部时皮带弯曲10毫米左右为宜, 调节时左右移动电机位置即可。
- 4)前后移动皮带轮,使V型皮带①和③各处都在一条直线上。

**\* How to install V belt Fig.2**

- 1) Mount high-speed V belt ① on accelerating pulley ② and the large diameters of the motor pulley.
- 2) Mount low-speed V belt ③ on low-speed pulley ④ and the small diameters of the motor pulley.

- 3) By moving the motor from side to side, adjust the tension of V belts ① and ③ so that they give an approx. 10 mm slack when their middle portions are pushed lightly by hand.
- 4) Move the motor pulley back and forth to align V belts ① and ③.

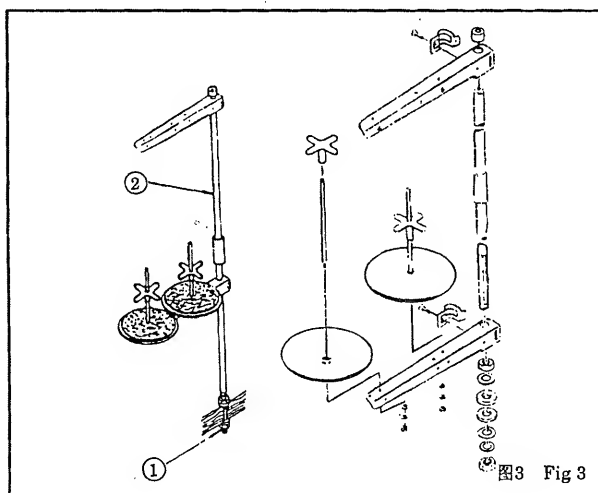


## 2. 线架的安装 图3

## 2. SETTING UP THE THREAD STAND Fig.3

将线架安装在台板孔中, 然后紧固螺母①, 动力电缆线可以通过线架杆②孔进入开关。

Assemble the thread stand, and fix it in the table hole. Then tighten lock nut ① to fix the thread stand. If ceiling wiring can be made, pass the power cable through spool rest rod ②.



### 3. 机头的安装 图4

### 3. SETTING UP THE MACHINE HEAD Fig.4

机头连接钩垫圈②放入机头连接钩①里, 将连接钩插入机器底板孔内, 然后将机头放在机壳底座上。  
Putting cushion ② into hinge ①, insert hinge ① into the machine head. Then, place the machine head on the machine base.

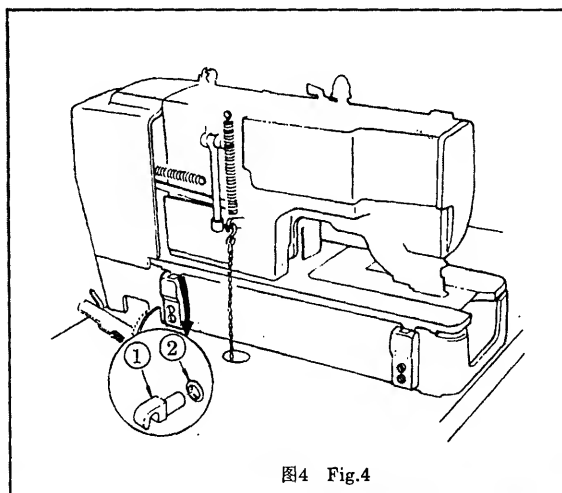


图4 Fig.4

### 4. 平皮带的安装方法 图5

### 4. ATTACHING THE FLAT BELT Fig.5

- 1) 拆下螺钉①并将弹簧②从弹簧钩上取出。此时, 切勿将启动推杆⑫朝箭头方向推。
  - 2) 将皮带③穿过变速拨叉④装在皮带轮上, 并使皮带朝箭头 ④ 方向转动。
  - 3) 将螺钉①和弹簧②装回原处。
  - 4) 按箭头方向抬高停车杠杆⑤将皮带从停车挡块⑥和止动分挡块⑦中间穿过。
  - 5) 将皮带装进变速机构皮带轮上以及一侧的皮带变速拨叉⑧内, 然后再装进压紧轮⑨中。
  - 6) 将压紧轮锁紧板⑩嵌进从下往上数的第二个压紧轮定位板上槽内⑪, 使皮带具有张力。
- 注意: 由于气温和湿度变化, 平皮带多少会产生伸缩现象, 安装时较困难, 但使用时, 会恢复原来长度, 因此不必担心。

- 1) Removing screw ①, remove spring ② from the suspension screw.

At this time, be careful not to push the starting link driving rod in the arrowed direction.

- 2) Pass belt ③ through belt shifter ④ so that the belt rotates in arrow ④ direction.

- 3) Reinstall screw ① and spring ②.

- 4) Lift tripping lever ⑤ in the direction, pass the belt between latch B ⑥ and latch A ⑦.

- 5) Passing belt shifter ⑧ of the speed transmitter, attach the belt onto tension pulley ⑨.
- 6) Put fixing pawl ⑩ in the second groove from the bottom of ratchet ⑪ to provide the belt with tension.

(NOTE) Some expansion or contraction in the belt caused by temperature or humidity may make it rather difficult to install the belt. However, the belt will restore its original length while in use.

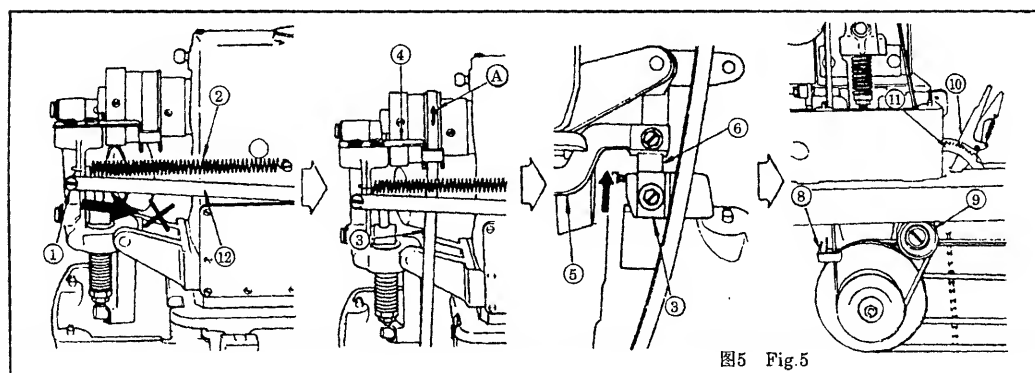


图5 Fig.5

## 5. 皮带罩的安装和拆卸 图6

## 5. INSTALLATION/REMOVAL OF BELT COVER Fig.6

将防护罩①上的孔 ④ 对准防护罩定位螺钉②装入, 再按箭头方向掀压防护罩, 直到发出“啪”的声音。卸取时, 按箭头反方向, 推倒防护罩后, 向上拉。

Aligning guide pin ② with hole ④ in belt cover ①, push the belt cover in the arrow direction until it snaps.

For removal of the belt cover, bring down the belt cover in the direction opposite to the arrow, and slide it up.

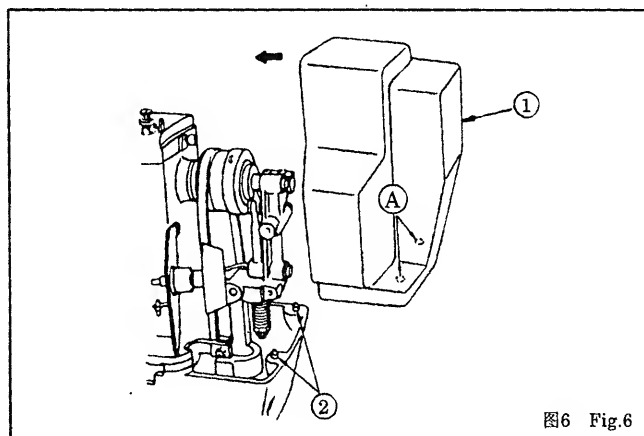


图6 Fig.6

## 6. 润滑

## 6. LUBRICATION

### \* 机器启动以前 图7

- 1) 将Singer C号油注入车壳底座内, 油量高度标记以“高”为准。
  - 2) 当油面降至油标①的下刻线以下时应添加油。
  - 3) 在机器处于正常的润滑状态时, 可以通过油窗②内的两根油管, 观察到油的流动。(低速运转时, 油的流动情况可以看得非常清楚)
- \* 油如被弄脏或有沉淀物后, 应松开螺钉③, 放掉废油, 换上新油。

### \* 旋梭的油量调节 图8

油量粗调时, 采用油量调节螺钉①来调节, 微调时, 采用旋梭油量调节螺钉②来进行。当顺时针旋进调节螺钉时, 油量会减少, 反之则增加。

### \* 其它部位的润滑

- 1) 每周或隔周在箭头所示部位加1—2滴润滑油。
- 2) 使用新机器或者长期搁置未用的缝纫机时, 在箭头 ④ 所示部位加2—3滴润滑油。

### \* Before starting the machine: Fig.7

- 1) Fill the oil reservoir of the machine base with singer oil type C up to the level indicated by "HIGH".
- 2) Supplement the oil when the oil level has lowered below the bottom line of oil gauge ①.
- 3) When the machine has been properly lubricated, the oil is seen to run through the pipe from oil sight window ②. (Low speed operation permits easier observation of the lubricating oil.)

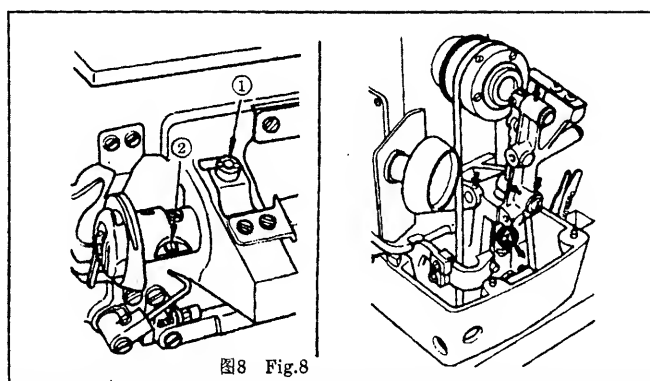
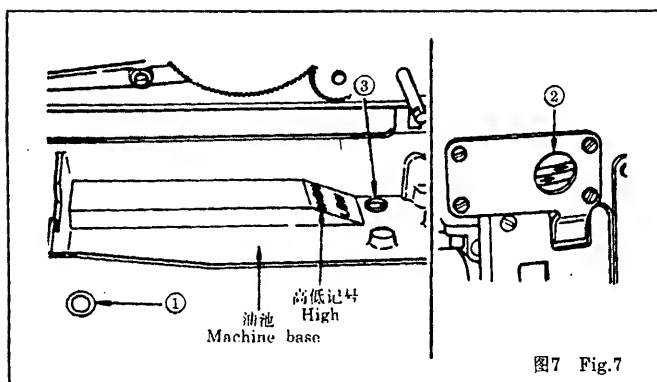
Drain dirty oil by loosening oil drain screw ③, and fill the oil reservoir with fresh oil.

### \* Adjusting the lubrication for the sewing hook Fig.8

Adjust the volume of lubricating oil supplied to the sewing hook by turning oil adjusting screws ① for rough adjustment, and ② for fine adjustment; oil volume is reduced when turning the screws clockwise.

### \* Other lubricating points

- 1) Apply one or two drops of lubricating oil to the arrowed points once a week or every other week.
- 2) Apply two or three drops of lubricating oil only to ④ point when the machine is newly set up or has been out of use for a long time.



## 7. 机针的安装方法 图9

### 7. HOW TO INSTALL THE NEEDLE Fig.9

\* 请关闭电源, 本机使用机针是锁眼机用针Singer N-1955

1) 旋松支针螺钉②将机针①的缺口转向操作者。

2) 将机针插进针杆孔内, 直至顶端。

3) 拧紧支针螺钉。

\* Turn off the motor power. Use needle cat. No. 1955-01.

1) Loosening needle setscrew ②, hold needle ① with its recessed part facing toward the operator,

2) insert the needle fully into the needle clamping hole, and

3) securely tighten the needle setscrew.



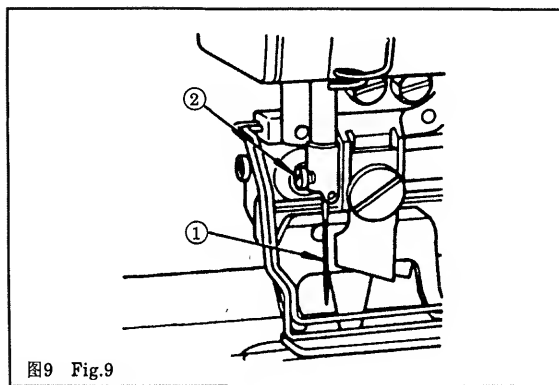


图9 Fig.9

### 8. 梭心套的取出和安装 图10

### 8. INSTALLATION/REMOVAL OF BOBBIN CASE Fig.10

- 1) 打开梭心套上的梭门盖①取出梭心套, 拿起开着的梭门盖, 梭心不会掉出。
- 2) 安装时, 将梭心套整个插进梭轴, 然后关闭梭门盖。
- 1) Lift up and hold bobbin case latch lever ① between two fingers to remove it from the hook. A bobbin does not fall off the bobbin case while the latch lever is lifted up.
- 2) For installation of the bobbin case, push the bobbin case into the hook so that it is supported by the hook shaft, and then snap in the latch lever.

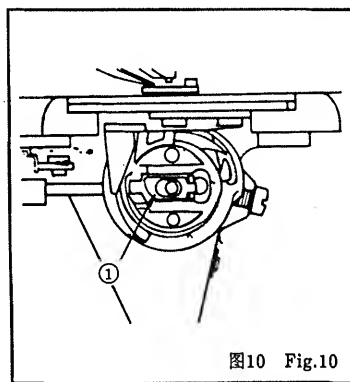
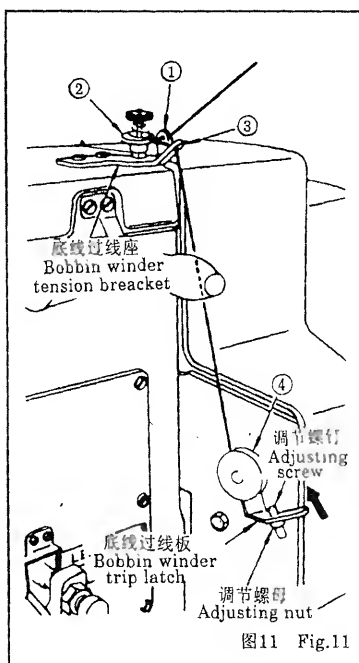


图10 Fig.10

## 9.底线的绕线方法 图11

### 9. WINDING THE BOBBIN Fig.11

- 1) 将梭心装进绕线轴。
  - 2) 按图的顺序穿线, 并在梭心上绕数圈。
  - 3) 将满成跳板朝箭头方向推上, 便可进行绕线。
  - 4) 绕线轴应控制在总绕线量的 $\frac{4}{5}$ 左右, 可通过旋松调节螺母, 将调节螺钉旋出或旋进来调节。
  - 5) 当绕线偏向一侧进, 移动过线架, 使其处于正确的绕线位置。
- 1) Fit a bobbin onto the bobbin winder shaft.
  - 2) Take the thread from the spool and pass it through the guides in the numerical order shown in the figure, and wind the end of the thread several turns around the bobbin.
  - 3) Push the bobbin winder trip latch in the arrow direction, and the bobbin will be wound.
  - 4) Loosening the adjusting nut, perform adjustment by screwing in or out the adjusting screw so that the bobbin is wound about four-fifths full.
  - 5) If the bobbin is wound unevenly, adjust the position of the bobbin winder tension bracket for proper and even winding.



## 10. 梭心的安装 图12

## 10. ATTACHING THE BOBBIN Fig.12

- 1) 拿住梭心, 将梭心装入旋梭内, 使梭心按逆时针方向转动。
- 2) 把线从梭子上线槽 ① 中穿过, 拉出底线, 并通过夹线簧下从线口 ② 处引出。

\* 当底线拉出太长, 可按箭头方向转动梭心来调节。

- 1) Hold and place a bobbin into the bobbin case so that the bobbin is wound counterclockwise.
- 2) Passing the thread through thread outlet ① of the bobbin case, pull the thread, and the thread can be drawn out from thread outlet ②, passing under the bobbin winder tension spring.

\* Set the bobbin so that it rotates in the arrow direction when the bobbin thread is pulled.

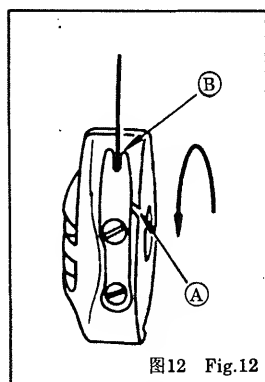


图12 Fig.12

## 11. 面线的穿法 图13

## 11. THREADING THE NEEDLE-THREAD Fig.13

- 1) 按图示的顺序穿面线。
- 1) Pass the needle thread in the order as shown in the figures.

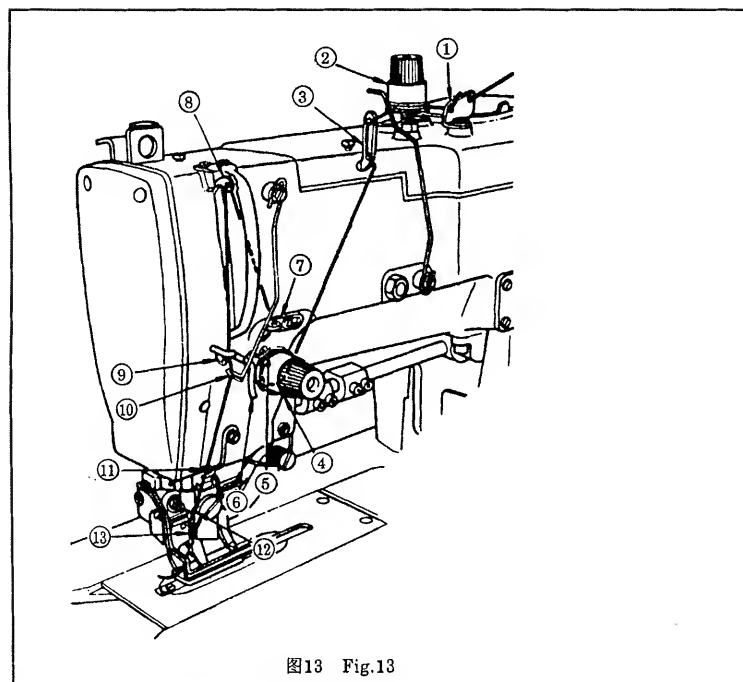


图13 Fig.13

## 12. 低速运转和紧急停车 图14

## 12. REDUCTION OF SEWING SPEED AND EMERGENCY STOP Fig.14

### \* 低速运转

1) 转动停车手柄①朝下到 ④ 位置。

2) 机器将立即变成低速运转。

### \* 紧急停车

1) 转动停车手柄朝下到 ④ 位置, 然后再朝上到 ⑤ 位置。

2) 机器将立即停车。

### \* Reduction of sewing speed

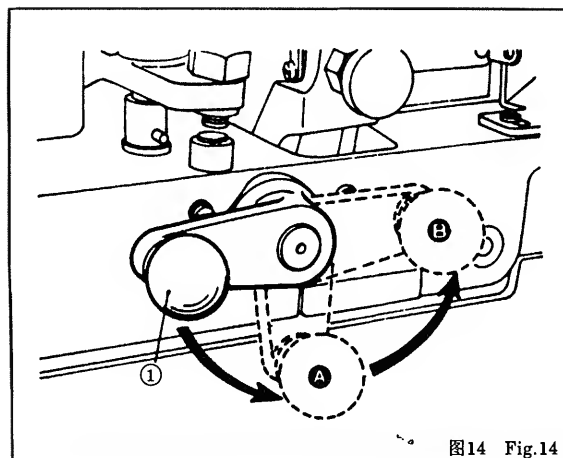
1) Turn hand stop crank ① downwards to position ④, and

2) the machine will be immediately slowed down.

### \* Emergency stop

1) Turn the hand stop crank downwards to position ④, and further upwards to position ⑤ and

2) the machine will stop immediately.



### 13.手动送料 图15

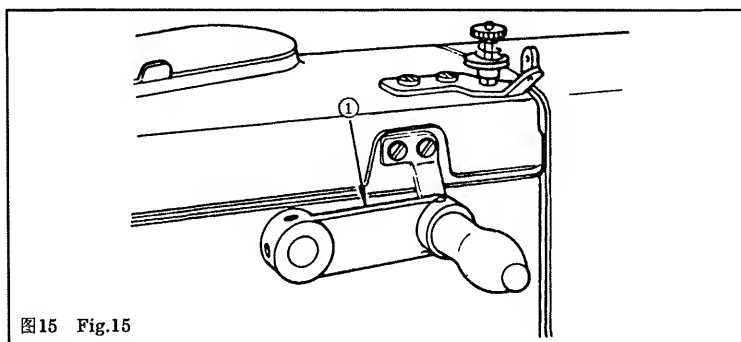
### 13. MANUAL FEED HANDLE Fig.15

在紧急停车或由于缝纫过程中的断线等原因,需要重新启动时,应转动手动送料手柄①使送布机构起动。

(注意)转动手动送料手柄前,应确认机针没有刺入缝料状态。

When you want to feed fabric manually after giving an emergency stop or to resume sewing from the point at which thread was broken, rotate manual feed handle ① to operate the cloth feeding mechanism.

(NOTE) Confirm that the needle does not stick in fabric before turning the manual feed handle.

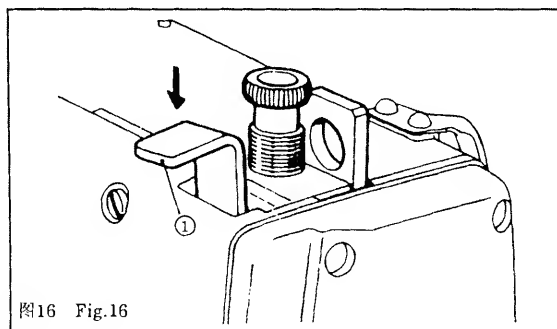


#### 14. 防止切刀降落的方法 图16

#### 14. HOW TO HOLD THE DESCENDING KNIFE Fig.16

在缝纫中由于断线或其它原因而不需要切刀时, 只要略向下掀压停刀杆①切刀就不会下降, 直到缝纫机操作结束。

When you do not want to cut fabric after sewing because of thread breakage or some other reasons, keep on pressing down knife stop lever ① lightly until the machine stops. Then the knife will not descend.



#### 15. 线迹型式 图17

#### 15. TYPES OF STITCHES Fig.17

本机器能缝出两种锁眼线迹, 即平缝线迹和三角缝线迹。

(平缝线迹)

平缝线迹是指在缝料表面只露面线, 缝料反面只露底线的锁眼线迹

(三角缝线迹)

三角缝线迹是指增加面线张力, 使面线从线迹的上面笔直穿过, 底线则从左右两边与面线交织形成的锁眼线迹。

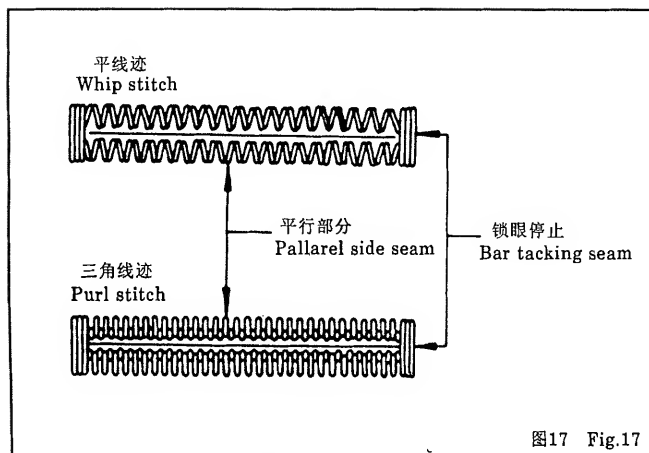
This machine is capable of forming two different types of stitches, namely whip stitch and purl stitch.

(Whip stitch)

The whip stitch is formed in zigzag showing the needle thread only on top of fabric, and the bobbin thread on the bottom.

(Purl stitch)

When applying higher tension to the needle thread to permit it to pass straight through fabric, the purl stitch is formed by the bobbin thread which is pulled over from both sides to the center line.



## 16. 缝线张力 图18 图19

## 16.THREAD TENSION Fig.18 Fig.19

### \* 三角线迹的缝线张力的调节

- 1) 用梭心套上的梭皮簧螺钉①调节底线张力, 使其张力达到15~20克左右。
- 2) 为了使套结部位形成美观的锁缝线迹, 可用第一夹线器②进行调节。如果张力过小的话, 在缝料背面套结口会形成线迹。
- 3) 横列部位的左右横针线迹由第二夹线器③来调节。

### \* 平缝线迹的缝线张力的调节

- 1) 梭皮簧螺钉①调节底线张力达到40~50克左右。
- 2) 互相调节第一夹线器②和第二夹线器③的夹线簧的压力。  
(第2夹线器有一只软弹簧)
- 3) 调节第二夹线器③以防在缝口收尾时拆散。
- 4) 第一夹线器②可以调节二边或横外的线迹。

### \* 调节挑线簧(三角线迹)

挑线簧①的行程约6—8毫米, 起动时的张力以20—50克为宜。

调节挑线簧行程: 旋松螺钉②将小起子插入夹线螺钉③的嵌槽内旋转即可。顺时针转动, 行程增大, 逆时针转动, 行程减小。调节挑线簧的张力: 旋松螺钉②用小起子插入夹线螺钉③的嵌槽内, 若顺时针转动, 张力增大, 逆时针转动, 则张力减弱。

### \* Adjusting the thread tension for purl stitch:

- 1) Adjust the bobbin thread tension to approx. 15 to 20g by adjusting screw ① of the bobbin case.
- 2) Adjust tension controller No. 1 ② for proper needle thread tension so that the bar-tack part is formed by well-shaped whip stitches. If the tension is too low, bar tacking seam may form thread knots on the rear face of fabric.

3) Adjust tension controller No. 2 ③ for proper tension of the parallel side seams by judging from the stitch formation.

**\* Adjusting the thread tension for whip stitch:**

- 1) Adjust the bobbin thread tension to approx. 40 to 50g by adjusting screw ① of the bobbin case.
- 2) Exchange the adjusting springs of tension controllers No. 1 ② and No.2 ③ each other (the tension controller No.2 will have a weak spring).
- 3) Adjust tension controller No.2 ③ to prevent ravelling off at the end of a seam.
- 4) The stitches of the parallel sides or bar-tack can be adjusted by tension controller No. 1 ②.

**\* Adjusting the thread take-up spring (for purl stitch)**

The suitable range of the stroke of thread take-up spring ① is from 6 to 8mm with a starting tension of 20 to 50g.

For adjusting the stroke of the thread take-up spring, loose screw ②, and insert a thin screwdriver into the slit of tension post ③ to turn the tension post.

To adjust the tension of the thread take-up spring, insert a thin screwdriver into the slit of tension post ③ to turn it, with screw ② tightened. The tension of the thread take-up spring increases when the tension post is turned clockwise, and decreases when turned counterclockwise.

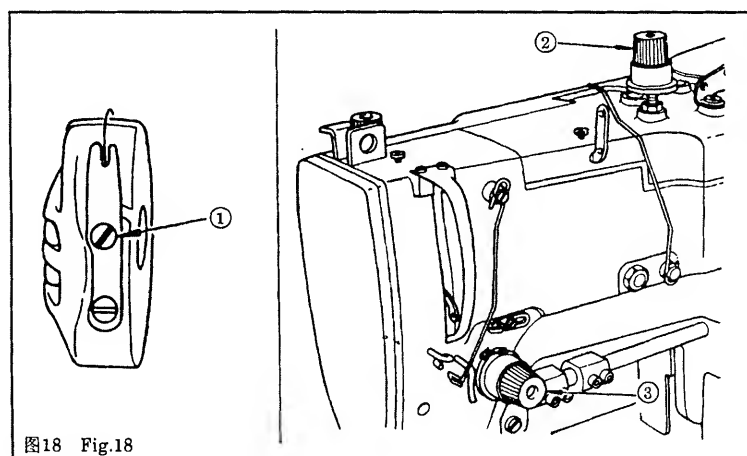


图18 Fig.18



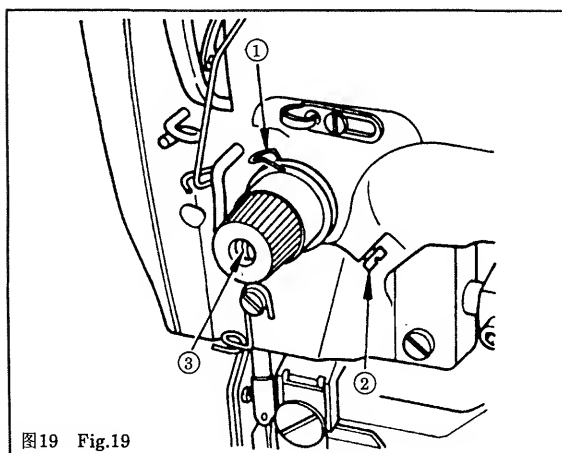


图19 Fig.19

## 17. 钮孔长度(送布量)的调节 图20

## 17. ADJUSTING THE OVEREDGING LENGTH(BUTTONHOLE LENGTH) Fig.20

1) 拉出推板①, 翻起内盖板②

2) 用附件扳手旋松螺母③, 将指针拨到送料曲柄⑤上所需的刻度位置。(与切刀宽度相同的尺寸) 然后拧紧螺母③。

3) 一边度缝, 一边进行微调, 使其切刀切不到钮孔的套结。

### \* 压脚板的选用

选用压脚板必须与钮孔长度相符。

通过旋松螺钉⑦来调换压脚板与相应的压脚板部件。

压脚板/压脚板部件型号	选用的刀宽
GM344/10	1/4"~3/4"
GM347/10	1/4"~1"
GM348/10	1/4"~1—1/4"

1) Pull out cover ①, and raise cover ②.

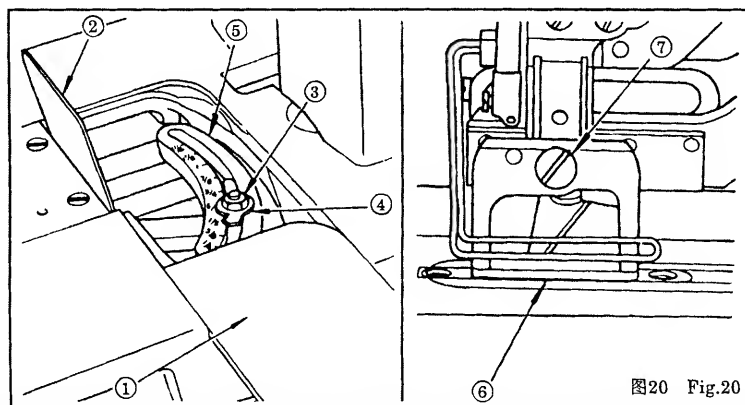
2) Loosen nut ③ by the spanner supplied with the machine. Set point ④ to a desired length on scale ⑤ (this length is the same with the knife width), and then retighten nut ③.

3) Through your trial sewing, adjust the overedging length accurately to the extent that the bar tacking seams are not cut by the knife.

**\* Changing the work clamp check**

Use work clamp check ⑥ having the size nearly the same as that of a buttonhole length. By removing setscrew ⑦, a work clamp checks can be changed together with a work clamp check holder as a set.

Work clamp check/Work clamp check holder set Part No.	Applicable knife width
GM344/10	1/4"~3/4"
GM347/10	1/4"~1"
GM348/10	1/4"~1-1/4"



**18. 切刀的调换 图21**

**18. REPLACING THE KNIFE Fig.21**

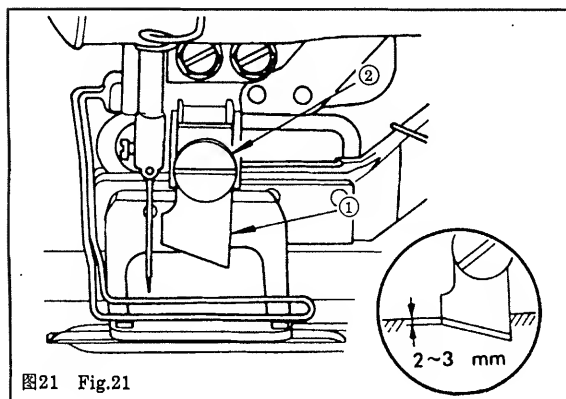
研磨切刀或调换新刀时, 应按下列步骤进行。

- 1) 旋松螺钉②将切刀连同垫圈一拉取下。
  - 2) 当切刀下落至最低位置时, 后刀刃与针板平面的距离保持2—3毫米。
- (注意): 在拧紧螺钉时, 不要忘记孔要加垫圈。

When sharpening or replacing the knife, remove it as follows:

- 1) Loosen setscrew ②, and remove knife ① together with the washer.
- 2) Attach the knife to the knife holder so that the higher end of the slanted knife blade comes down 2 to 3mm above the surface of the throat plate when the knife is brought down to the lowest position.

(NOTE): Do not forget to install the washer when retightening the setscrew.



## 19. 锁眼宽度(横列宽度和套结宽度)和锁眼基准位置的调节

## 19. ADJUSTING THE OVERDGING WIDTH (STITCH WIDTH AND BAR TACKING WIDTH) AND OVEREDGING REFERENCE POSITION

机针的摆动是以左、右横列的右侧作为基准位置的。

按照下列步骤进行调节

- 1)横列宽度 ① 的调节可通过旋转螺钉①, 将指针②拨在调节杆连接板③刻度上所需位置。实际的横列宽度仅是所需刻线值的二分之一。
- 2)套结宽度 ② 的调节可通过旋转螺钉④, 将指针⑤拨在调节杆连接板刻线上所需位置。套结宽度是横列宽度的2倍。
- 3)右基线 ③ 位置的调节可通过旋转螺钉⑥,使右基线处在不被切刀切去右横列缝线的位置上。当拧入螺钉⑥,右基线就向左移动。
- 4)通过试缝,进一步调节好。
- 5)不需要调节左横列的左基线 ④ 位置, 因为当线迹宽度变化时, 它保持不变, 但是如果被切刀切去缝线时, 只要通过拧入螺钉⑦, 使左基线向左移动。

The needle swings from right to left with the right base line established as the reference position.

Perform the adjustment as follows

- 1) To adjust stitch width ①, screw in or out screw ①, and set pointer ② to a desired value on scale plate ③. The actually sewn stitch width will be the half of the set scale value (mm).
- 2) For adjustment of bar tacking width ②, screw in or out screw ④, and set pointer ⑤ to the value indicated by scale plate pointer ②, making the bar tacking width twice as large as the stitch width.

- 3) Adjust the position of right base line ③ by screwing in or out screw ⑥ so that it is kept away from the cutting line of the knife. As screw ⑥ is screwed in, the right base line moves to the left.
- 4) Through your trial sewing, further perform fine adjustment.
- 5) It is not necessary to adjust the position of left base line ④ since it remains unchanged when the stitch width is changed. However, the left base line should be moved to the left by screwing in screw ⑦ if it is cut by the knife.

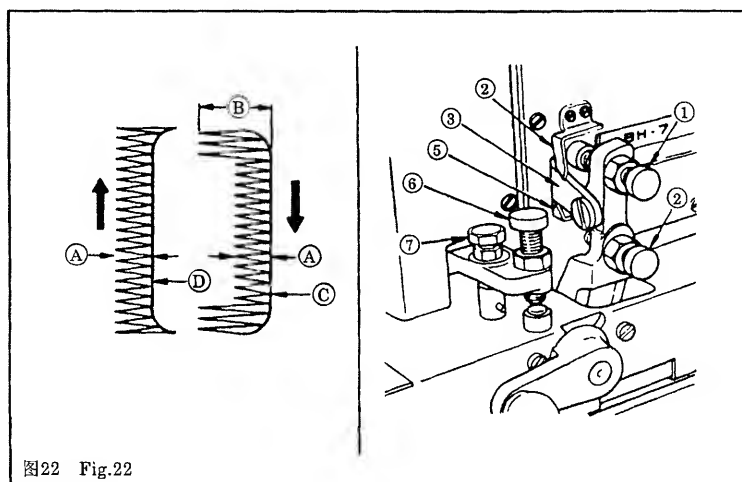


图22 Fig.22

## 20. 针数的变换

## 20. CHANGING THE NUMBER OF STITCHES

### \* 调换齿轮

- 1) 通过齿轮的选择, 可获得表格中所示的针数。
- 2) 所示齿轮都刻有A.B.C……等字母以及123.152等数字标记。
- 3) 采用字母相同的大、小齿轮进行组装。
- 4) 装在后面位置的齿轮上所刻的数字表示那些已组合了的齿轮所提供的针数。
- 5) 1371A1机上已安装N号齿轮, 另有G号、J号、L号三对齿轮作为附件。  
1371A2机上已安装L号齿轮, 另有G号、J号、N号三对齿轮作为附件。  
1371A3机上已安装H号齿轮, 另有G号、J号、L号、N号四对齿轮作为附件。

记号	提供的针迹数目	提供的针迹数目	记号	提供的针迹数目	提供的针迹数目
A	54	345	I	93	200
B	62	300	Ⓜ	100	190
C	66	285	K	105	180
D	70	268	Ⓛ	110	170
E	74	252	M	115	160
F	79	238	Ⓝ	123	152
ⓖ	83	225	O	130	145
H	88	212			

上述表格中那些画圈的字母符号表示: 这些齿轮包括在标准附件内。所有其他的齿轮均为供用户选择定购的附件。

**\* 齿轮的安装 图23**

- 1) 先将齿轮①插进蜗轮轴里和靠近操作者一侧的交换齿轮挡圈②上的定位销内。
- 2) 再将齿轮③一边按箭头方向旋转, 一边插进离操作者远的交换齿轮挡圈④上的定位销内和送料凸轮传动轴里。

**\* 变速凸块位置的调节**

旋松紧定螺钉⑤, 调节变速凸块位置, 使间隙Ⓐ符合下表所列的值:

针数	间隙Ⓐ
93针以下	10—12毫米
115针以下	5毫米
123针	0~2毫米

**\* Spur gears**

- 1) By selecting the spur gears, you can control the number of stitches as shown in the table.
- 2) Alphabetical marks like A,B,C, etc., and numerals like 123, 152, etc. are both engraved on each spur gear for identification.
- 3) Use a combination of gears which have the same alphabetical marks.
- 4) The numeral engraved on the gear installed in the rear position will represent the

5) The machine head installed a couple of gears (symbol N)for 1371A1; The oter three couples of gears (symbol G、J、L) are as accessories.

The machine head installed a couple of gears (symbol L)for 1371A2; The oter three couples of gears (symbol G、J、N) are as accessories.

The machine head installed a couple of gears (symbol H)for 1371A3; The oter four couples of gears (symbol G、J、L、N) are as accessories.

Symbol	No. of stitches	No. of stitches	Symbol	No. of stitches	No. of stitches
A	54	345	I	93	200
B	62	300	ⓐ	100	190
C	66	285	K	105	180
D	70	268	ⓑ	110	170
E	74	252	M	115	160
F	79	238	ⓒ	123	152
ⓓ	83	225	O	130	145
H	88	212			

number of stitches provided by the combination of spur gears.

The circled alphabetical symbols in the above table show that the gears are included in the standard accessories. All other gears are optional attachments.

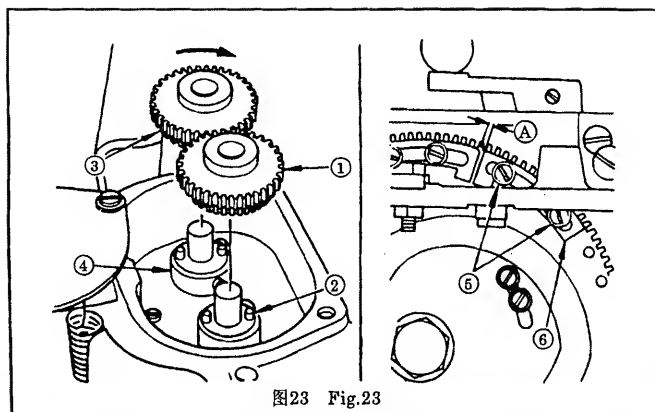
**\* Attaching the spur gears to their shafts** Fig.23

- 1) Push gear ① into the shaft so that it is securely fixed by the pin on gear bushing ② located nearer to an operator.
- 2) For installing gear ③ on the pin of rear gear bushing ④ , push gear ③ into the shaft while turning it in the arrow direction.

**\* Adjusting the low-speed cam position**

Loosen setscrews ⑤, and adjust the position of low-speed cam ⑥ to set clearance ⑦ as shown below:

Number of stitches	Clearance ⑦
93 stitches or less	10~12 mm
115 stitches or less	5 mm
123 stitches	0~2mm



## 21. 压脚压力的调节 图24

## 21. ADJUSTING THE PRESSER BAR PRESSURE Fig.24

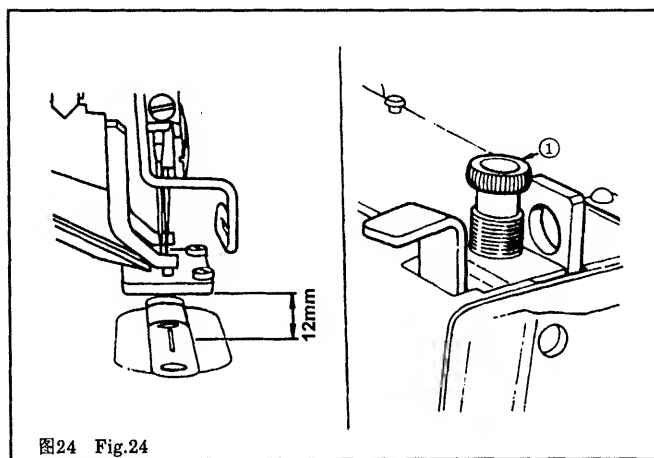
压脚提升量: 是指在踏板踩足时, 压脚高度12mm。

压脚压力可由调压螺钉①来进行, 如拧入调压螺钉, 压脚压力就增大, 缝料不易产生折皱现象。

The presser bar goes up 9mm when the pedal is fully stepped down.

To adjust the pressure applied by the presser bar to fabric, turn presser spring regulator

①. When the pressure is not enough to prevent fabric from puckering, turn regulator ① clockwise.



## 22. 针与旋梭配合 图25

## 22. NEEDLE-TO-HOOK RELATION Fig.25

\* 机针与旋梭的配合由下列方法调节:

1) 机针落在针板孔中央, 同理针杆处在最低位置。

2) 旋松针杆连接轴螺钉①调整针杆的高度。

(针杆的定位)

3) 将定位样板尺②的“1”部分插进针板③和针杆④下端的间隙内, 然后放下针杆, 使其碰到样板尺。

4) 旋紧针杆连接轴螺钉调整旋梭的位置。

(旋梭的定位)

5) 旋松旋梭接套螺钉⑤

6) 从操作者位置看, 顺时针方向转动皮带轮, 使针杆从最低点进入开始上升状态。

7) 再将样板尺的“2”部分插进针板与针杆下端之间, 使针杆碰到定位样板尺。

8) 将梭尖⑥对准机针⑦的中心线, 机针与梭尖的间隙约为0.05毫米, 然后拧紧旋梭接套螺钉。

(注意): 如果出现跳针现象时, 可将针杆高度从定位样板尺“1”位置降低0.5毫米。

\* **Set the needle to hook relation in the following way:**

1) Bring down the needle bar to the lowest point when the needle is coming down through the center of the needle hole on the throat plate.

2) Loosen needle bar connection screw ①, and adjust the height of the needle bar.

**(Setting the needle bar)**

3) Insert the part “1” of timing gauge ② into the gap between the bottom end of needle bar ④ and throat plate ③.

4) Retighten the needle bar connection screw to adjust the position of the sewing hook.

**(Setting the hook)**

5) Loosen setscrew ⑤ of the hook sleeve by the bar spanner supplied with the machine.

6) Rotate the driving pulley in the correct direction until the needle starts to go up from its lowest point.

7) Insert the part “2” of the timing gauge into the gap between the bottom end of the needle bar and the throat plate, where the bottom end of the needle bar touches the top of the part “2” of the timing gauge.

8) Align blade point ⑥ of the sewing hook with the center of needle ⑦, and make adjustment so that a clearance of approx. 0.5mm (1/64") is provided between the needle and the blade point of the hook. Then, securely retighten the setscrew of the hook sleeve.

**(NOTE): If stitches are skipped, lower the needle bar by approx. 0.5mm (1/64") from the timing gauge "1".**



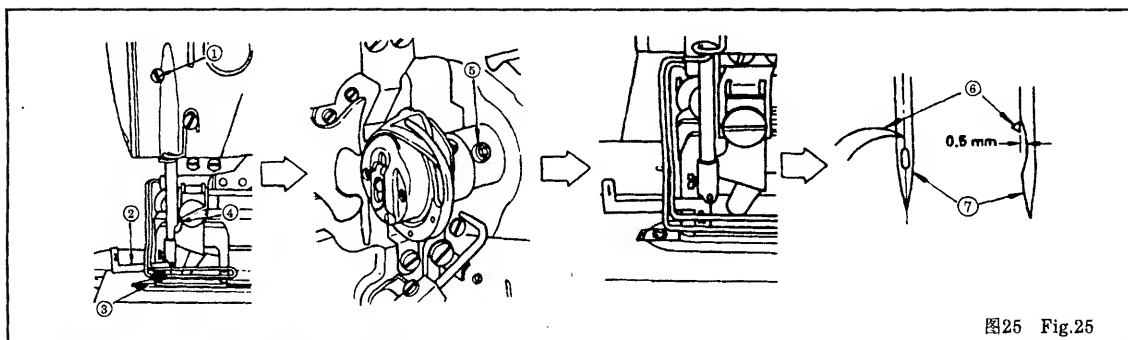


图25 Fig.25

### 23.底线绕线装置的调节 图26

### 23. ADJUSTING THE BOBBIN THREAD WINDER Fig.26

底线绕线轮①处于脱离状态时, 应使绕线轮①与皮带④间隙在1毫米左右, 可通过旋松螺钉②来调节。

然而, 如果皮带碰触绕线器, 只须通过张紧轮③调节张力, 就能减少皮带的偏转移动量。但是, 经过调节, 皮带仍旧碰触绕线器, 将绕线器与皮带之间的间隙增至1毫米以上即可。

Loosen screw ② to make adjustment so that the clearance between bobbin thread winder pulley ① and belt ④ becomes approx. 1mm (3/64") when pulley ① is apart from the belt. If, however, the belt touches the pulley, adjust the tension by tension pulley ③ to decrease the deflection of the belt. And if the belt still touches the pulley, increase the clearance to more than 1mm (3/64").

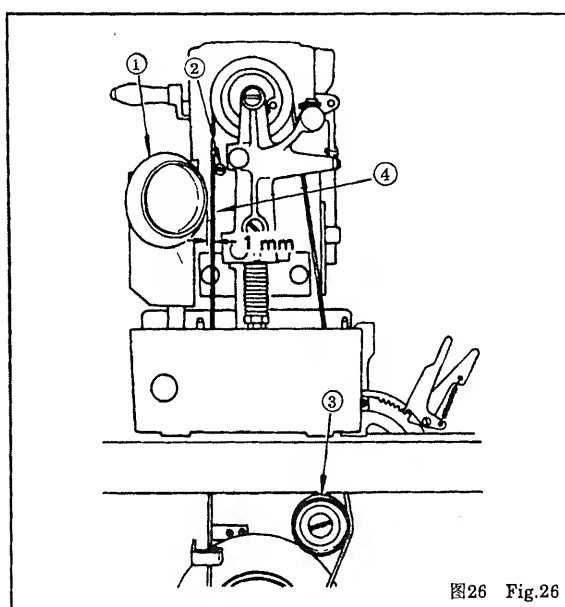


图26 Fig.26

## 24. 变速机构的调节 图27

## 24. ADJUSTING THE SPEED TRANSMITTER Fig.27

### \* 皮带拨叉的位置调节

当停车手柄转到低速状态时, 旋松螺钉③, 移动皮带拨叉②的位置, 使皮带移到低速皮带轮①的位置。

### \* 限位螺钉调节

在高速运转时, 为了不使皮带从高速皮带轮④中脱出, 皮带拨叉②可用限位螺钉⑤来调节。

### \* Adjustment of the position of the belt shifter

When the hand stop crank is turned down to the low speed position, loosen screw ③ and allow the belt to move onto low-speed pulley ①, moving the position of belt shifter ②.

### \* Adjusting the stopper screw

Perform adjustment by stopper screw ⑤ so that belt shifter ② does not cause the belt to come off high-speed pulley ④ during high speed operation.

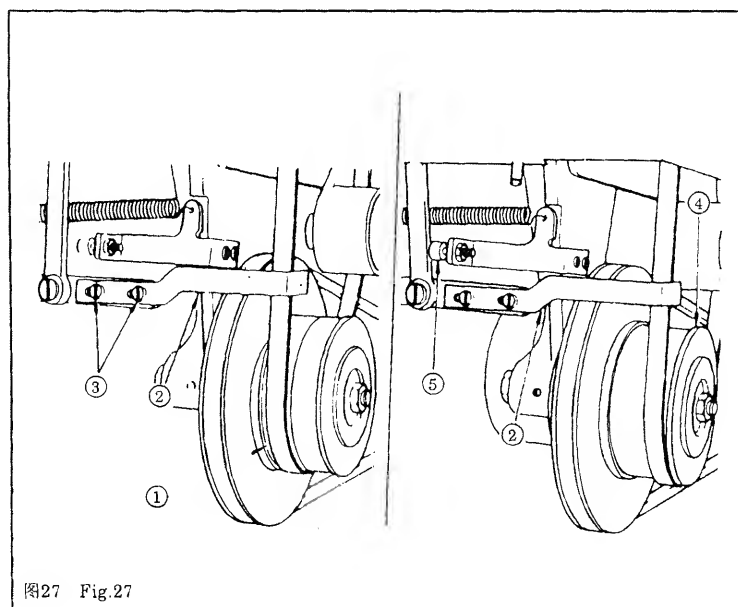


图27 Fig.27

## 25. 面线剪刀的调节 图28

## 25. ADJUSTMENT OF THE NEEDLE THREAD TRIMMER Fig.28

### \* 调整面线剪刀

旋松螺钉①, 调节面线剪刀③的高度, 在压脚②与剪刀③不相接触的范围内尽量安装低一些, 这样可减少面线的线头量。

**\* 剪刀的闭合时间的调节**

当剪刀向前进足时,剪刀正进入闭合状态。按此标准调节剪刀的闭合时间。

旋松螺钉④使闭剪控制板⑤前后移动。若往操作者一侧移动闭合时间会推迟,同时闭剪量也减少。

(注意):当面剪刀完全处于闭合状态时,刀口的线量应留有0.3—0.5毫米的余量,若不留余量,就会与闭剪控制板⑤撞合,在抬高抬压脚杠杆⑦时,会感到沉重。

**\* 剪刀的开启时间的调节**

缝纫机起始缝纫约2.5—3毫米处,剪刀开始张开,以此标准进行调节

调节的步骤是,旋松螺钉④使开剪控制板⑥前后移动,若往操作者一侧移动,则开启时间会提前。

(注意):勿使业已固定的面线剪线板④脱离位置。

**\* Attaching the trimmer**

Loosen setscrew ①, and adjust the height of trimmer ③. Set the height of trimmer ③ as low as possible, provided that it does not touch work clamp check ②, in order to minimize the length of remaining thread on the needle after trimming.

**\* Closing timing of the needle thread trimmer**

Adjust the closing timing of the needle thread trimmer so that the trimmer completely colses when it advances farthest.

To perform the adjustment, loosen screw ④, and move needle thread trimmer driving plate A ⑤ back and forth. When the needle thread trimmer driving plate is moved towards you, the closing timing is delayed with reduced amount of closing.

(NOTE) Confirm that an allowance of 0.3 to 0.5 mm is left between the blades of the trimmer when the trimmer has completely closed.

If there is no such allowance, the trimmer would interfere with the operation of the needle thread trimmer driving plate, preventing smooth movement of lifting lever ⑦.

**\* Opening timing of the needle thread trimmer**

Adjust the timing of the thread trimmer so that the trimmer begins to open gradually at a distance of approx. 2.5 to 3mm (3/32" to 1/8") from the start.

To perform the adjustment, loosen screw ④, and move needle thread trimmer driving plate B ⑥ back and forth. As it moves towards you, the trimmer begins to open earlier.

(NOTE): Take care not to cause the already fixed needle thread trimmer driving plate A to get out of position.

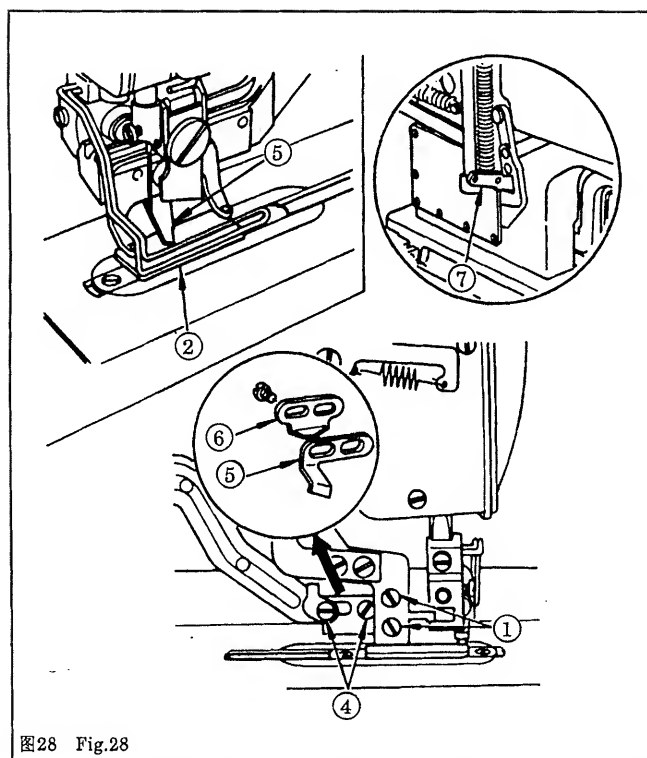


图28 Fig.28

## 26. 面线剪刀托架和面线剪刀限位板的调节 图29

## 26. ADJUSTMENT OF NEEDLE THREAD TRIMMER HOLDER AND LIMITING PLATE Fig.29

旋松螺钉④安装和调节面线剪刀限位板⑤使其与限位杠杆③相接触,此时机器处于低速启动状态。(停车挡块①和止动分挡块②相啮合)

当面线剪刀张开时,面线剪刀托架⑥与传动凸块⑦啮合部分应为0.5毫米。

Loosen setscrew ④, and install and adjust limiting plate ⑤ so that it comes in contact with the blocking arm ③ at the time of slow start of the machine (when latch B ① is engaged with latch A ②).

Needle thread trimmer holder ⑥ should be installed in such manner that it engages with cam ⑦ by 0.5mm (1/64") when the needle thread trimmer opens.

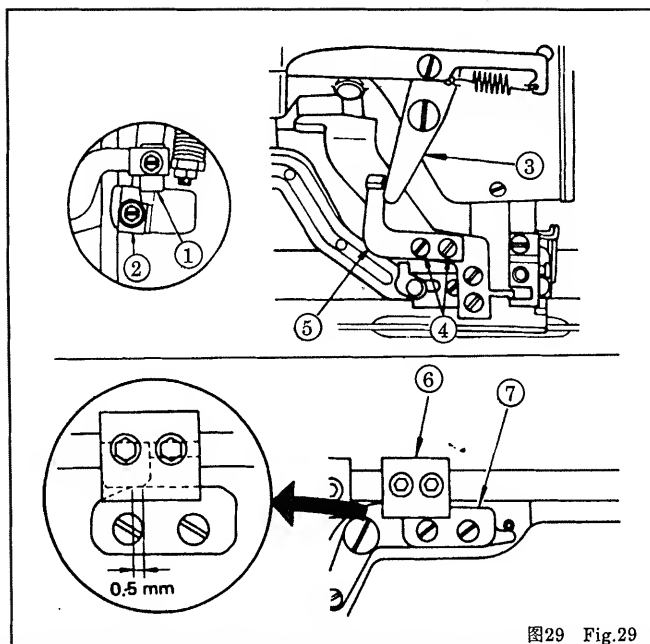


图29 Fig.29

## 27. 切刀时间的调节 图30

## 27. TIMING FOR DROPPING THE KNIFE Fig.30

旋松螺钉①,按箭头方向移动切刀凸块②,切刀时间将提前。以缝纫机停车前2—3针时切刀为标准进行调节。

Loosen screws ①, and move knife tripping segment ② in the direction shown by the arrow, and the knife will drop earlier. Adjust it so that the knife drops two to three stitches before the machine stops.

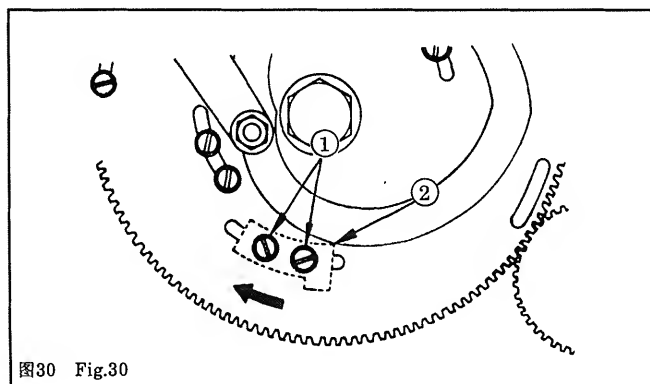


图30 Fig.30

## 28.故障、原因和排除方法

## 28. TROUBLE, CAUSE, AND REMEDY

故障内容	原因	排除方法	页数
1. 断面线	(1)第二夹线器张力过大	(1)减小第二夹线器张力	20
	(2)挑线簧行程和张力的过大	(2)减小挑线行程和张力的	20
	(3)梭尖部位有毛刺或有毛病	(3)梭尖磨光或调换旋梭	
	(4)针与旋梭配合不好	(4)用样板尺校正针与旋梭的配合	29
	(5)穿线方法不正确	(5)按正确方法穿线	16
	(6)机针太细	(6)调换粗针	13
2. 面线脱线	(1)面线剪刀开启时间过早	(1)将开剪控制板向后移	31
	(2)压脚下降时面线剪刀有些张开	(2)将开剪控制板向后移	31
	(3)缝纫机启动时, 平线迹不形成	(3)增加第一夹线器的张力	20
	(4)穿线不对	(4)按正确方法穿线	16
3. 横列部位线迹紊乱	(1)第二夹线器张力过小	(1)增大第二夹线器张力	20
	(2)挑线簧行程和张力的不足	(2)调整挑线簧	20
	(3)底线张力太大	(3)减小底线张力(三角线迹张力在15-20克)	20

4. 缝纫开始时线迹 紊乱	(1)第一夹线器张力过小	(1)增大第二夹线器张力	20
	(2)面线剪力位置太高	(2)剪刀位置应尽量装得低些,但不能 与压脚相碰	31
	(3)挑线簧行程过大	(3)减少挑线簧行程,增大挑线簧压力	20
5. 第一套结部位 从缝料背面露出线 圈	(1)第一夹线器张力过小	(1)增大第一夹线器张力	20
	(2)底线张力过大	(2)减小底线张力(15-20克)	20
6.浮线	(1)底线张力不足	(1)增大底线张力	20
	(2)梭子上穿线不对	(2)按正确的穿线方法	16
7. 跳针	(1)压脚板相对于纽孔太大	(1)调用适当的压脚板	22
	(2)缝料太薄	(2)推迟机针与旋梭的配合时间(针杆 高度可降低0.5毫米)	29

Trouble	Cause	Remedy	Page
1. Needle thread is broken.	(1) The tension of the tension controller No. 2 is too tight.	○ Decrease the tension of the tension controller No. 2	20
	(2) The tension of the stroke of the take-up spring is too great.	○ Decrease the tension or the stroke of the take-up spring.	20
	(3) Blade point of sewing hook has burr or scratches.	○ Buff the blade point of the sewing hook, or replat the sewing hook.	29
	(4) Poor timing of the sewing hook.	○ Readjust the sewing hook's timing by the timing gauge.	16
	(5) The thread path has scratches.	○ Buff the thread path by cloth files, etc.	13
	(6) The needle is too thin.	○ Replace by a thick needle.	
2. Thread slips out of the needle.	(1) The needle thread trimmer opens too early.	○ Move back the needle thread trimmer driving plate B.	31
	(2) The needle thread trimmer opens when the work clamp check is coming down.	○ Move back the needle thread trimmer driving plate B.	31
	(3) The whip stitch is not formed at the start of sewing.	○ Decrease the tension of the tension controller No.1.	20
	(4) Wrong threading.	○ Perform correct threading.	16
3. Wobbling stitches are formed in the overedging seams.	(1) The tension disc No. 2 is too loose.	○ Increase the tension of the tension disc No.2.	20
	(2) The tension and stroke of the take-up spring is not enough.	○ Readjust the take-up spring.	20
	(3) Bobbin thread tension is too high.	○ Decrease the bobbin thread tension (15 to 20g for purl stitches).	20
4. Wobbling stitches are formed at the start of sewing.	(1) The tension disc No. 1 is too loose.	○ Increase the tension of the tension disc No. 1 (15 to 30g).	20
	(2) The position of the needle thread trimmer is too high.	○ Lower the trimmer as low as possible, provided it does not come in contact with the work clamp check.	31
	(3) The stroke of the take-up spring is too great.	○ Decrease the stroke of the take-up spring, and increase the spring pressure.	20
5. The needle thread at the first bar tacking comes out and lumps on the bottom of cloth.	(1) The tension disc No. 1 is too loose.	○ Increase the tension of the tension disc No. 1.	20
	(2) The bobbin thread tension is too high.	○ Decrease the bobbin thread tension (15 to 20g).	20
6. Stitches float over cloth.	(1) Bobbin thread tension is not enough.	○ Increase the bobbin thread tension.	20
	(2) Bobbin thread slips out of the thread path on the bobbin case.	○ Properly thread the bobbin case.	16
7. Stitches are skipped.	(1) The work clamp check is too large for the buttonhole.	○ Change the work clamp check with a smaller one.	22
	(2) The cloth is made of light-weight materials.	○ Delay the timing of the needle and the sewing hook. (lower the needle bar by approx. 0.5mm (1/64"))	29



## 29. 由其他原因引起的故障

## 29. STITCHING TROUBLES CAUSED BY OTHER REASONS

故障内容	原因	排除方法	页数
1. 起动踏板不工作 (抬压脚杠杆没有完全复位)	(1) 针板、针板座、底线剪刀部分嵌入线头等杂物。 (2) 面线剪刀碰到压脚板或面线开, 闭剪控制板	(1) 倾倒机头, 清除杂物 (2) 重新安装面线剪刀或重新调节面线开, 闭剪控制板位置	31
2. 即使踏板踏足亦无高速运转	(1) 停车手柄不在正确位置 (2) 变速机构的拨叉没有移到高速皮带轮一侧	按正确的方法安装停车手柄向拨叉传动销添加润滑油	17
3. 止动时声音太大 或者缝制结束无减速	(1) 变速凸块调整不正确, 不能进行少针数缝纫(工作) (2) 平皮带太松 (3) 低速三角皮带太松	(1) 重新调节变速凸块。 (2) 增大平皮带张力 (3) 增大三角皮带张力	25 10 8
4. 止动不良	(1) 止动机构要润滑 (2) 变速机构的皮带拨叉移不到低速皮带轮一侧	(1) 向止动机构添加润滑油 (2) 重新调节皮带拨叉的位置	12 31
5. 不供油	(1) 机头底座中油量不足 (2) 油不能循环	(1) 加油至“高”标记 (2) 向循环油毡添加油	12 12

6.高速运转时切刀不落	(1)切刀凸块位置不对	(1)调节切刀降落时间(推迟)	34
	(2)针数少时的变速凸块位置不对	(2)调节变速凸块位置	25
7.即使面线断,切刀也会降落	(1)机器穿线不正确	(1)纠正穿线过程	16
8.断针	(1)机针弯曲	(1)调换机针	13
	(2)机针与梭尖相碰	(2)重新调节机针与梭尖位置	29
	(3)面线剪刀张开时,碰到机针	(3)重新调节剪刀位置	31
		(4)使面线控制板与控制板压板相碰	31

Trouble	Cause	Remedy	Page
1. Starting pedal does not work. (The work clamp arm is not lifted up fully.)	(1) Needle plate, needle plate base or bobbin thread trimmer is clogged with fibrous dust. (2) The needle thread trimmer is interfered by the work clamp check or the trimmer driving plate.	○ Tilt the machine head and clean them up.  ○ Readjust the installation of the trimmer, or the position of the trimmer driving plate.	31
2. Machine does not reach the high speed even when the pedal is stepped down fully.	(1) The hand stop crank is not in the correct position. (2) The belt shifter of the speed transmitter has not changed to the high speed pulley.	○ Correct the position of the hand stop crank. ○ Lubricate the shifter driving pin.	17
3. A loud noise is produced with a stop-motion, or sewing speed does not lower at the end of sewing.	(1) Improper setting of the low speed cam for small numbers of stitches.	○ Readjust the setting of the low speed cam.	25
	(2) The flat belt is too loose.	○ Increase the belt tension by the tension pulley.	10
	(3) The low speed V belt is too loose.	○ Increase the tension of the V belt by the motor.	8
4. Stop-motion is not smooth.	(1) Stop-motion lever needs lubrication.	○ Lubricate the stop-motion lever.	12
	(2) The belt shifter of the speed transmitter has not changed to the low speed pulley.	○ Readjust the position of the belt shifter.	31
5. The machine does not lubricate.	(1) Oil level in the oil reservoir is too low.	○ Fill the lubricating oil up to "HIGH" mark.	12
	(2) Oil is not circulated.	○ Apply oil to the oil return felts.	12
6. Knife is dropped during high speed rotation.	(1) Position of the knife tripping segment is not correct.	○ Adjust the position of the driving cam so that the knife is dropped down at a delayed timing.	34
	(2) The setting of the low speed cam for numbers of stitches is not correct.	○ Correct the setting of the low speed cam.	25
7. Knife is dropped even if the needle thread is broken.	(1) The machine is threaded incorrectly.	○ Correct the threading.	16
8. Needle is broken.	(1) The needle is bent.	○ Replace the needle.	13
	(2) The needle and the hook blade touch with each other.	○ Readjust the positions of the needle and the sewing hook.	29
	(3) Needle thread trimmer hits the needle when opening its blades.	○ Readjust the position of the trimmer.	31
		○ Adjust so that the limiting plate and the blocking arm touch each other at the time of starting.	31

### 30. 规格

### 30. SPECIFICATIONS

	1371A1	1371A2	1371A3
用途	普通棉、针织物等的锁钮孔		
缝速	最大3000针/分		
钮孔长度	6.4—19.0mm (1/4" — 3/4")	6.4—25.4mm (1/4" — 1")	6.4—31.7mm (1/4" — 1 $\frac{1}{4}$ ")
加固宽度	2.5—4.0 (3/32" — 5/32")	2.5—5.0mm(3/32" — 3/16")	
机针	CAT. 1955-01		
压脚提升高度	12mm(15/32")		
润滑油	SINGER " C " OIL		

	1371A1	1371A2	1371A3
Application	Buttonholing for ordinary cloth, knit, etc.		
Sewing speed	Max. 3, 000 s.p.m.		
Buttonhole length	6.4—19.0mm (1/4" — 3/4")	6.4—25.4mm (1/4" — 1")	6.4—31.7mm (1/4" — 1 $\frac{1}{4}$ " )
Bar-tack width	2.5—4.0 (3/32" — 5/32")	2.5—5.0mm(3/32" — 3/16")	
Needle	CAT. 1955-01		
presser lift	12mm(15/32")		
Lubricating oil	SINGER " C " OIL		

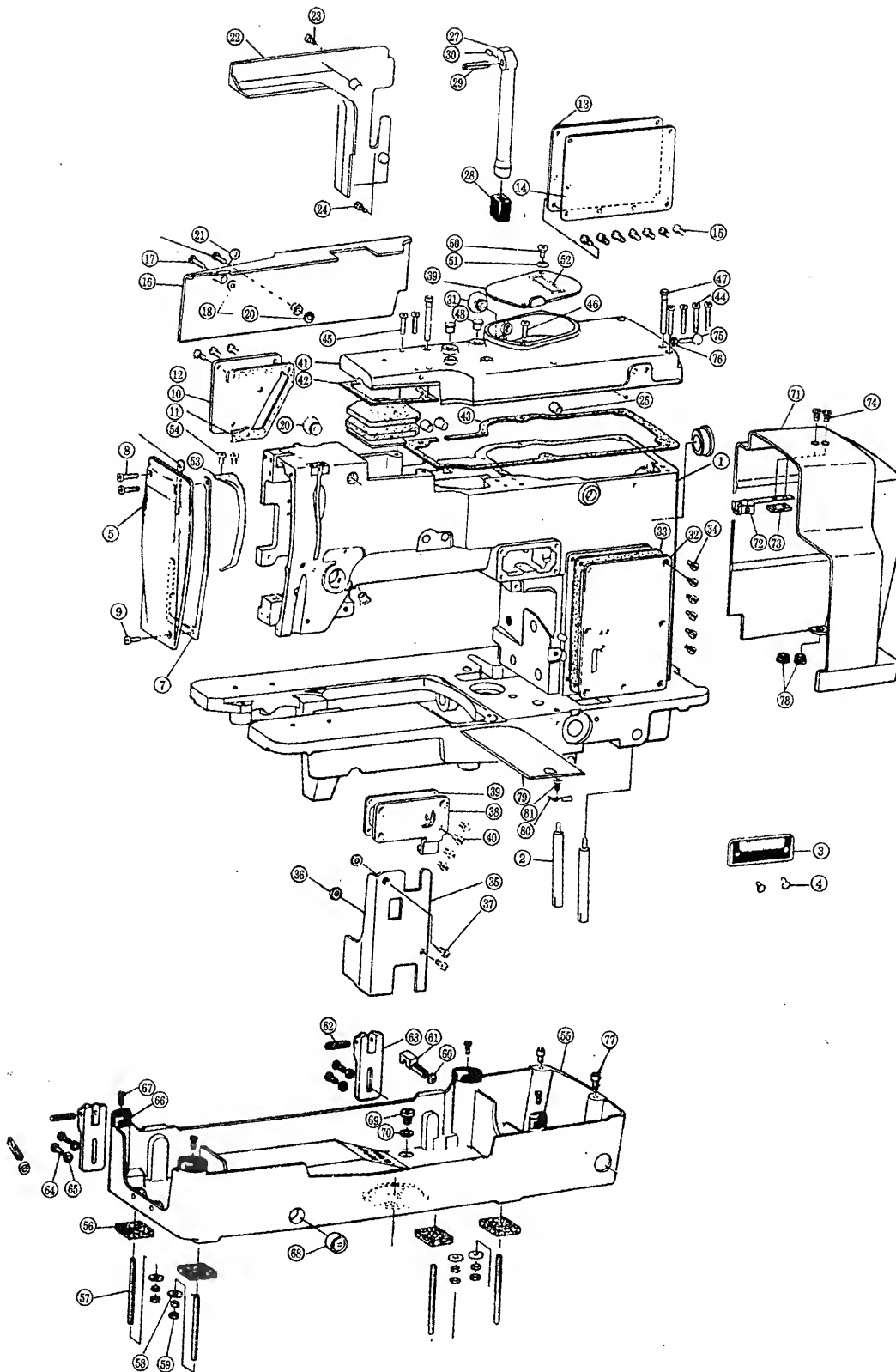
零件样本

**ILLUSTRATED PARTS LIST**

## 1、机壳分组件

## 1. Frame and miscellaneous cover components

序号 Ref.No.	件 号 Part No.	名 称 Description	数量 Amt.
1	GX332-S	车壳组件.....	1
2	GS0584	底板支柱.....	2
3	GQ284 A1	型号牌(1371A1).....	1
	GQ284 A2	型号牌(1371A2).....	1
	GQ284 A3	型号牌(1371A3).....	1
4	GX333	型号牌铆钉.....	2
5	GR3436/2	盖板部件.....	1
6	GR3438	左盖板垫.....	1
7	GR3439	右盖板垫.....	1
8	GS0585	面板上螺钉.....	2
9	GS037	面板下螺钉.....	1
10	GK248	面板左侧盖板.....	1
11	GR3440	面板左侧盖板垫.....	1
12	GS100	左侧盖板螺钉.....	3
13	GK249-S	左侧后盖板.....	1
14	GR3441	左侧后盖板垫.....	1
15	GS100	左侧后盖板螺钉.....	7
16	GK250-S	左侧上罩盖.....	1
17	GS0585	左侧上罩盖长螺钉.....	1
18	GR3442	左侧上罩盖长螺钉垫圈.....	1
19	GS079	左侧上罩盖螺钉.....	1
20	GR3442	左侧上罩盖螺钉垫圈.....	1
21	GR3443	左侧上罩盖螺钉肩垫圈.....	1
22	GK251	左侧下罩盖.....	1
23	GS079	左侧下罩盖长螺钉.....	1
24	GS100	左侧下罩盖螺钉.....	1
25	GR1461	定位螺钉孔塞.....	3
26	GR1463	针杆同轴螺钉孔塞.....	1
27	GR3445	机头侧柱.....	1
28	GR3446	机头侧柱垫.....	1
29	GX581	机头侧柱销.....	1
30	GS013	机头侧柱销紧固螺钉.....	1
31	GR1463	齿轮螺钉孔孔塞.....	1
32	GK252	右侧后罩盖.....	1
33	GR3447	右侧后罩盖垫.....	1
34	GS100	右侧后罩盖螺钉.....	7
35	GK253	右侧下罩盖.....	1
36	GR3448	右侧下罩盖垫圈.....	2
37	GS100	右侧下罩盖螺钉.....	2
38	GK254/2	油窗板部件.....	1
39	GR3450	油窗板垫.....	1
40	GS100	油窗板螺钉.....	4
41	GK256	上盖.....	1
42	GR3451	上盖前垫.....	1
43	GR3452	上盖后垫.....	1
44	GS0142	上盖长螺钉.....	4
45	GS0585	上盖螺钉.....	2
46	GS0586	上盖短螺钉.....	1
47	GX582	上盖销钉.....	2
48	GR1461	上盖油孔塞.....	2
49	GK257	交换齿轮箱箱盖.....	1
50	GS0587	铰链螺钉.....	1
51	GR3453	铰链螺钉垫圈.....	1
52	GQ285	齿轮箱箱盖板.....	1
53	GK258	挑线杆护罩.....	1
54	GS0588	挑线杆护罩螺钉.....	2
55	GQ286	机壳底座.....	1
56	GR3454	机壳底座垫.....	4
57	GS0589	机壳底座螺钉.....	4
58	GR3455	机壳底座螺钉垫圈.....	4
59	GL15	机壳底座螺钉螺母.....	4
60	GR3456	机头连接钩垫圈.....	2
61	GR3457	机头连接钩.....	2
62	GX581	机头连接销.....	2
63	GR3458	机头铰接座.....	2
64	GS0590	机头铰接座螺钉.....	4
65	GR3459	机头铰接座螺钉垫圈.....	4
66	GR3460	机头座垫.....	4
67	GS037	机头座垫螺钉.....	4
68	GR3461/3	油杯部件.....	1
69	GS0591	放油螺钉.....	1
70	GR3465	螺钉垫圈.....	1
71	GK259	防护罩.....	1
72	GW441	防护罩锁紧簧.....	1
73	GR3466	防护罩锁紧簧压板.....	1
74	GS100	锁紧簧压板螺钉.....	2
75	GS0592	球形锁紧柱.....	1
76	GL20	锁紧柱螺母.....	1
77	GS0593	防护罩定位螺钉.....	2
78	GO480	定位螺钉孔塞.....	2
79	GM343	推板.....	1
80	GW442	推板簧.....	1
81	GS0106	推板簧螺钉.....	1

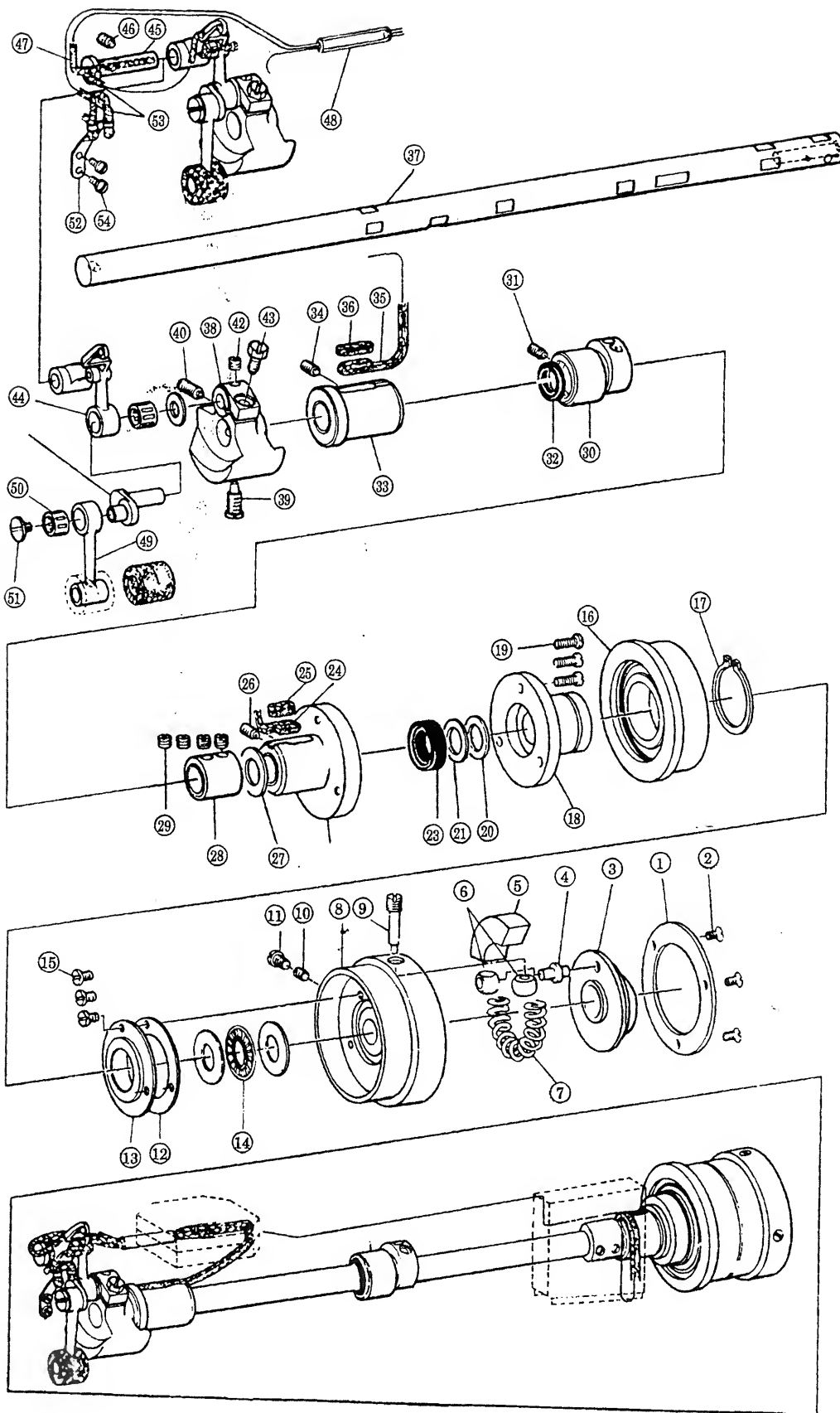


## 2、上轴、挑线分组件

## 2.Main shaft components

序号 Ref.No.	件号 Part No.	名 称	Description	数量 Amt.
1	GR3467	止动凸轮压圈	Stop motion cam presser plate	1
2	GS044	止动凸轮压圈螺钉	Screw 11/64-40 L=6.8	3
3	GT200	止动凸轮	Stop motion cam	1
4	GX583	止动凸轮销	Stop-motion cam position pin	1
5	GR1261	止动块	Bakelite segment	1
6	GU210	止动凸轮销滑块	Stop-motion cam pin slide block	2
7	GW212	止动凸轮压簧	Stop cam pressure spring	1
8	GP170	止轴带轮	Driving pulley	1
9	GS0594	带轮定位螺钉	Screw (c)	1
10	GS0595	带轮紧固螺钉	Screw 1/4-40 L=5	1
11	GS0596	带轮螺钉塞	Screw 1/4-40 L=5.0	1
12	G0387	轴承盖垫	Gasket	1
13	GR3468	带轮轴承盖	Main shaft thrust seal	1
14	GR3469	带轮轴承	Thrust washer a	1
15	GS0116	轴承盖螺钉	Screw 9/64-40 L=3.5	3
16	GP171/2	上轴停车带轮部件	Loose pulley asm.	1
17	GR3470	停车带轮轴承挡圈	Retaning ring 30	1
18	GR3471	停车带轮安装座	Bearing retainer	1
19	GS037	安装座螺钉	Screw 11/64-40 L=10.5	3
20	GR3472	安装座薄垫圈	Washer	1
21	GR3473	安装座厚垫圈	Washer	1
22	GO482/2	上轴后轴套部件	Main shaft bushing, rear	1
23	GR3474	后轴套油封	Oil seal	1
24	GR3475	后轴套厚油毡	Oil wick	1
25	GR3476	后轴套薄油毡	Oil wick	1
26	GS48	后轴套螺钉	Screw 15/64-28 L=7	1
27	GR3477	后轴套垫圈	Main shaft thrust washer (C)	1
28	GR3478	后轴套挡圈	Main shaft thrust collar asm.	1
29	GS0597	挡圈螺钉	Screw 1/4-40 L=4.5	4
30	GO485	上轴中轴套	Main shaft bushing, intermediate	1
31	GS04	上轴中轴套螺钉	Screw 15/64-28 L=10.5	1
32	GR3474	上轴中轴套油封	Oil seal	1
33	GO486/2	上轴中轴套部件	Bushing, front	1
34	GS48	前轴套螺钉	Screw 15/64-28 L=7	1
35	GR3479	前轴套长油毡	Oil wick	1
36	GR3480	前轴套短油毡	Oil felt	1
37	GZ443/2	上轴部件	Main shaft	1
38	GH580	针杆曲柄	Counterweight	1
39	GS0598	针杆曲柄定位螺钉	Screw 9/32-28 L=16	1
40	GS0156	针杆曲柄螺钉	Screw 9/32-28 L=16	1
41	GH581	挑线曲柄	Needle bar crank	1
42	GS39	挑线曲柄定位螺钉	Screw 1/4-40 L=6	1
43	GS0599	挑线曲柄螺钉	Screw 1/4-40 L=12	1
44	GH582/9	挑线杆部件	Thread take-up lever asm.	1
45	GX584	挑线连杆销	Hinge stud	1
46	GS04	挑线连杆销螺钉	Screw 15/64-28 L=10.5	1
47	GR3482	挑线连杆销油线	Oil wick	1
48	GO490	挑线连杆销油线套	Vinyl tube, white D=6	1
49	GH586/3	针杆连杆部件	Oil felt washer	1
50	GO270	针杆连杆滚针轴承	Needle bearing, B	1
51	GS09	挑线曲柄左旋螺钉	End screw left	1
52	GR3484	挑线连杆销油线夹	Oil wick holder	1
53	GR3485	油线夹油线	Oil wick	1
54	GS043	油线夹螺钉	Screw 9/64-40 L=4	2

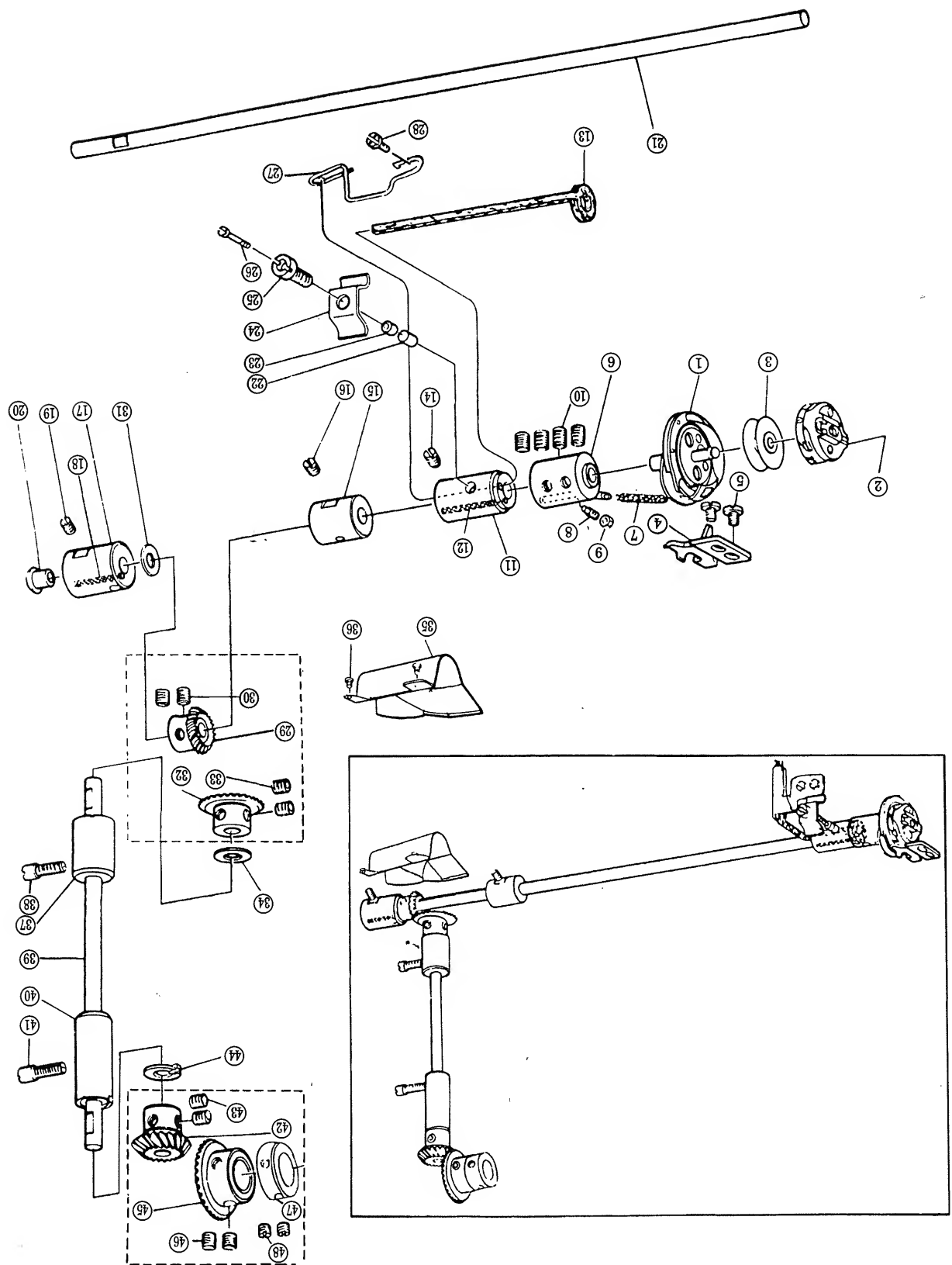




### 3、下轴分组件

序号	件 号	名 称	数量
Ref.No.	Part No.	Description	Amt.
1	GN200	旋梭部件 .....	1
2	GN201	梭子部件 .....	1
3	GN202	梭心 .....	1
4	GR3486	旋梭定位钩 .....	1
5	GS0600	旋梭定位钩螺钉 .....	2
6	GO491/7	旋梭接套部件 .....	1
7	GR3488	旋梭油线 .....	1
8	GS0601	旋梭油量调节螺钉 .....	1
9	GL48	旋梭油量调节螺母 .....	1
10	GS0602	旋梭接套螺钉 .....	4
11	GO494	下轴前轴套 .....	1
12	GR3490	下轴前轴套油线 .....	1
13	GR3491	下轴前轴套长油线 .....	1
14	GS48	下轴前轴套螺钉 .....	1
15	GO495	下轴中轴套 .....	1
16	GS48	下轴中轴套螺钉 .....	1
17	GO496	下轴后轴套 .....	1
18	GR3492	下轴后轴套油线 .....	1
19	GS48	下轴后轴套螺钉 .....	1
20	GR3493	下轴后轴套油塞 .....	1
21	GZ445	下轴 .....	1
22	GR3495	油量调节橡皮 .....	1
23	GO497	油量调节套 .....	1
24	GR3496	油量调节螺钉座 .....	1
25	GS0603	油量调节螺钉 .....	1
26	GS0604	油量调节定位螺钉 .....	1
27	GR3497	油线夹 .....	1
28	GS062	油线夹螺钉 .....	1
29	GC201	下轴伞齿轮 .....	1
30	GS0605	下轴伞齿轮螺钉 .....	2
31	GR3498	下轴伞齿轮垫圈 .....	1
32	GC202	竖轴下伞齿轮 .....	1
33	GS0605	下伞齿轮螺钉 .....	2
34	GR3499	下伞齿轮垫圈 .....	1
35	GK260	下轴伞齿轮罩板 .....	1
36	GS010	罩板螺钉 .....	2
37	GO498/2	竖轴下轴套部件 .....	1
38	GS0606	竖轴下轴套螺钉 .....	1
39	GZ446	竖轴 .....	1
40	GO501/2	竖轴上轴套部件 .....	1
41	GS0606	竖轴上轴套螺钉 .....	1
42	GC203	竖轴上伞齿轮 .....	1
43	GS0605	上伞齿轮螺钉 .....	2
44	GR3498	上伞齿轮垫圈 .....	1
45	GC204	上轴伞齿轮 .....	1
46	GS0605	上轴伞齿轮螺钉 .....	2
47	GR1469	上轴伞齿轮挡圈 .....	1
48	GS0597	挡圈螺钉 .....	2

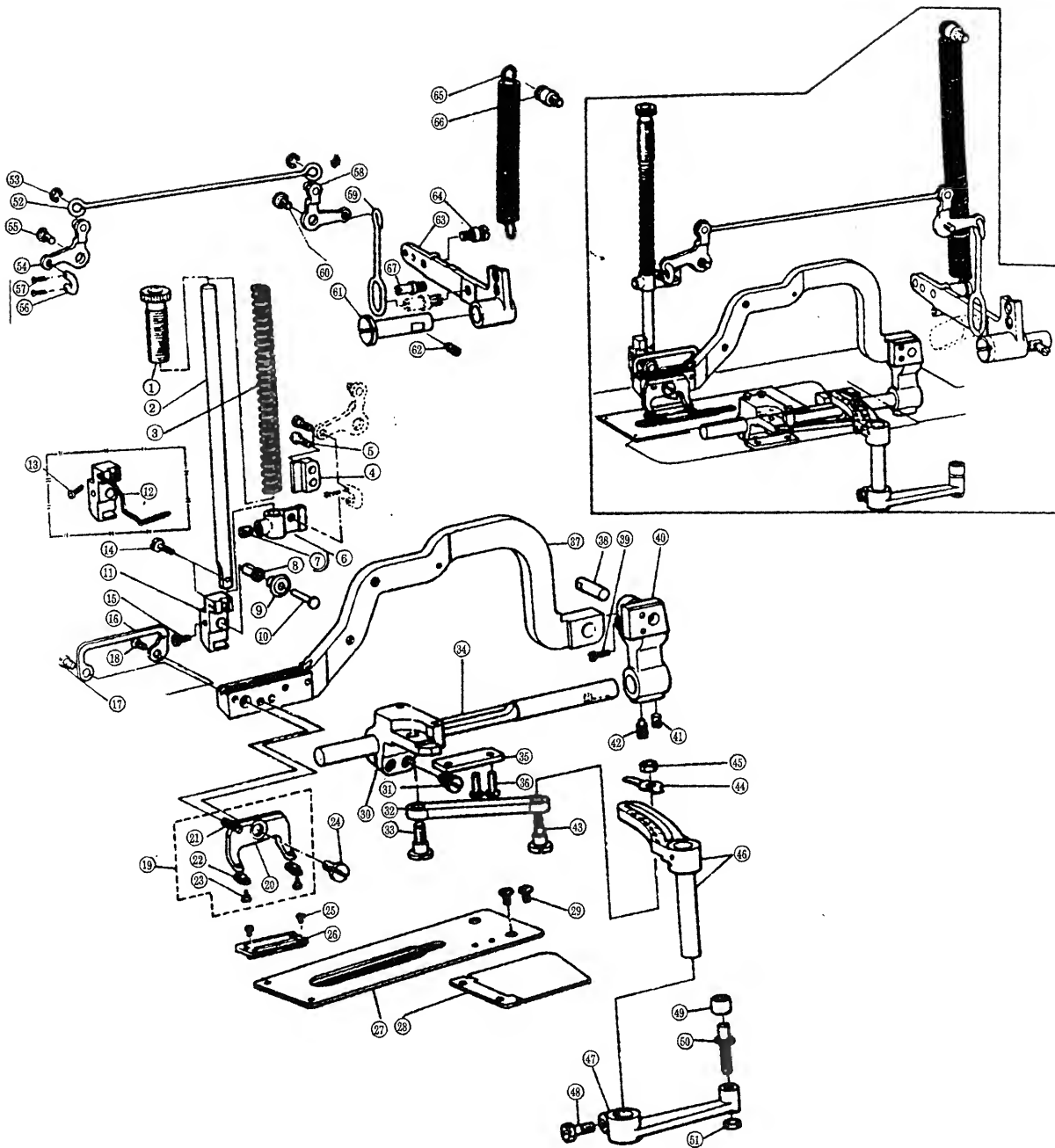
### 3. Hook driving shaft components



## 4、压脚送料分组件

## 4.Presser bar work clamp carrier components

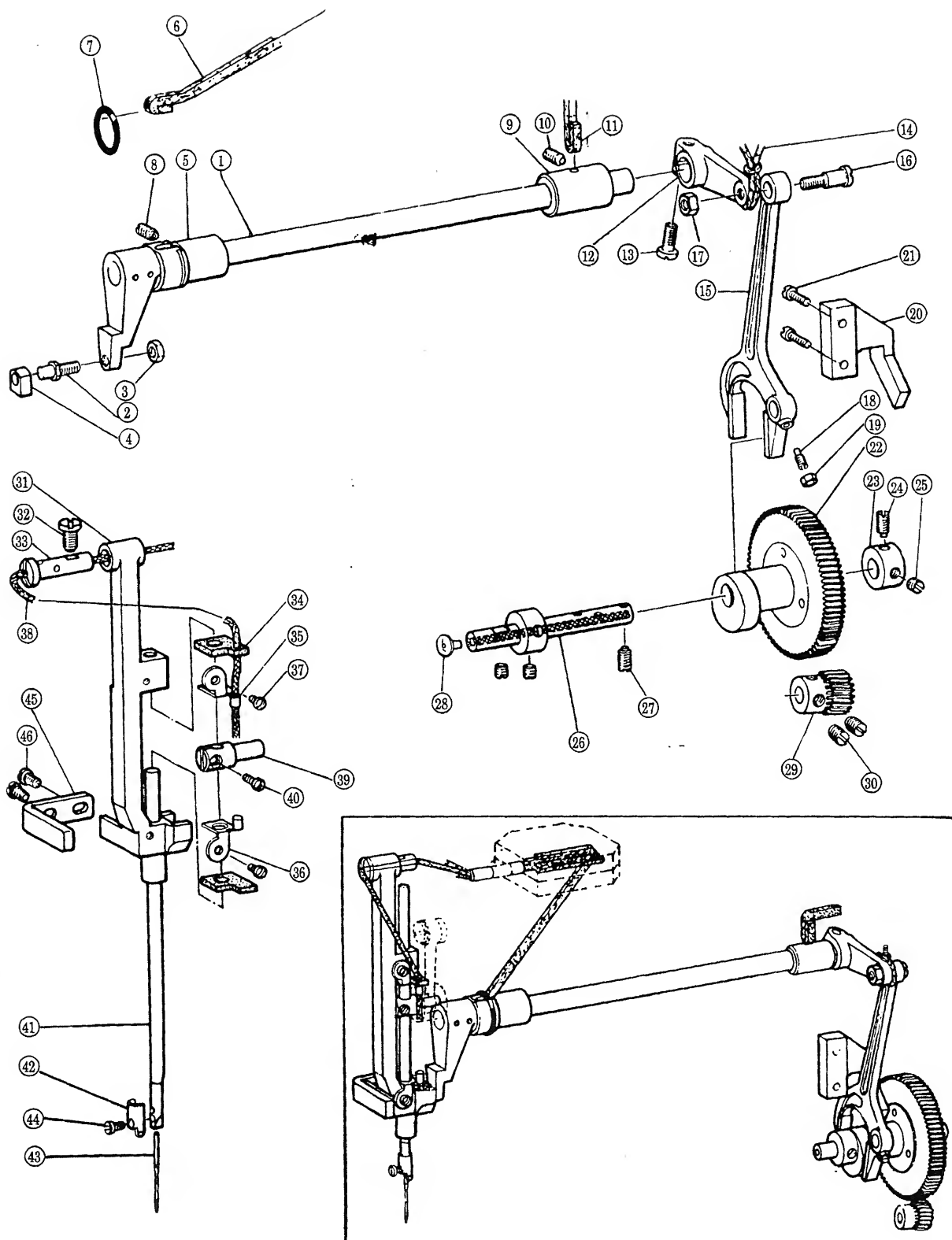
序号 Ref.No.	件号 Part No.	名 称	Description	数量 Amt.
1	GS0607	调压螺钉	Presser spring regulator	1
2	GZ447	压杆	Presser bar	1
3	GW443	压杆簧	Presser spring	1
4	GR3500	压杆导架定位块	Presser bar guide bracket	1
5	GS0586	定位块螺钉	Screw 11/64-40 L=12.8	2
6	GR3501	压杆导架	Presser bar position bracket asm	1
7	GS033	压杆导架螺钉	Screw 1/4-40 L=8	1
8	GO504	压脚滚轮套	Collar	1
9	GR1306	压脚滚轮	Slide roller	1
10	GX585	压脚滚轮销	Connecting pin	1
11	GR3502	压脚滚轮架	Bracket	1
12	GR3503	保针架	Finger guard	1
13	GS011	保针架螺钉	Screw 9/64-40 L=6	1
14	GS0608	滚轮架螺钉	Screw 9/64-40 L=15	1
15	GS0106	滚轮套螺钉	Screw 11/64-40 L=7	1
16	GR3504	压脚提升架	Work clamp bracket	1
17	GS0609	压脚提升架前螺钉	Screw 11/64-40 L=8.2	1
18	GS044	压脚提升架后螺钉	Screw 11/64-40 L=8.5	1
19	GM344/10A1	压脚部件(1371A1)	Work clamp check holder asm.(for 1371A1)	1
	GM344/10A2	压脚部件(1371A2)	Work clamp check holder asm.(for 1371A2)	1
	GM344/10A3	压脚部件(1371A3)	Work clamp check holder asm.(for 1371A3)	1
20	GR3505	压脚柄	Work clamp check holder	1
21	GW444	压脚簧	Work clamp check holder spring	1
22	GR3506	压脚板弹簧片	Work clamp check spring	2
23	GX299	压脚板弹簧销	Work clamp check spring set pin	2
24	GS0610	压脚柄轴位螺钉	Hinge screw D=7.94 H=1.5	1
25	GS045	压脚板螺钉	Screw 3/32-56 L=1.9	2
26	GR3507/2A1	压脚板部件(1371A1)	Work clamp check (for 1371A1)	1
	GR3507/2A2	压脚板部件(1371A2)	Work clamp check (for 1371A2)	1
	GR3507/2A3	压脚板部件(1371A3)	Work clamp check (for 1371A3)	1
27	GM345	压脚拖板	Work clamp carrier	1
28	GK261/3	拖板架盖板部件	Bracket cover	1
29	GS0611	拖板螺钉	Screw 11/64-40 L=8	2
30	GR3511	拖板架	Work clamp arm bracket asm	1
31	GS090	拖板架螺钉	Screw 15/64-28 L=14	1
32	GH588	钮孔长度连杆	Work clamp carrier bracket pitman	1
33	GS0612	钮孔长度连杆轴位螺钉	Hinge screw D=8.73 H=6.0	1
34	GZ448	送料轴	Work clamp arm slide rod	1
35	GR3512	拖板架导板	Work clamp carrier bracket guide	1
36	GS030	拖板架导板螺钉	Screw 11/64-40 L=9.5	2
37	GR3513	抬压脚送料杆	Work clamp	1
38	GX587	抬压脚送料杆杆销	Connecting pin	1
39	GS0613	抬压脚送料杆杆销螺钉	Screw 9/64-40 L=8.5	1
40	GR3514	抬压脚送料杆杆座	Bearing arm	1
41	GS48	送料轴螺钉	Screw 15/64-28 L=7	1
42	GS0614	送料轴定位螺钉	Screw 15/64-28 L=11.0	1
43	GS0615	钮孔长度调节螺钉	Length regulating hinge stud	1
44	GR3515A1	钮孔长度指针(1371A1)	Length regulating shaft guide (for 1371A1)	1
	GR3515A2	钮孔长度指针(1371A2)	Length regulating shaft guide (for 1371A2)	1
	GR3515A3	钮孔长度指针(1371A3)	Length regulating shaft guide (for 1371A3)	1
45	GL15	钮孔长度调节螺母	Nut 15/64-28	1
46	GH589/3	送料曲柄部件	Length regulating scale asm.	1
47	GH591	送料下曲柄	Bell crank asm.	1
48	GS0616	送料下曲柄螺钉	Screw 15/64-28 L=15.5	1
49	GU211	送料下曲柄滚柱	Roller	1
50	GS0617	滚柱销螺钉	Bell crank roller stud	1
51	GL15	滚柱销螺母	Nut 15/64-28	1
52	GH592	抬压脚长拉杆	Presser bar lifting rod, long	1
53	GR1510	抬压脚长拉杆挡圈	Snap ring 5	2
54	GR3516/2	抬压脚前拉杆部件	Lever asm, front	1
55	GS026	抬压脚前拉杆轴位螺钉	Hinge screw D=7.24 H=3.3	1
56	GR1299	抬压脚前拉杆连接钩	Link	1
57	GX122	连接钩开口销	Split pin	2
58	GR3518/2	抬压脚后拉杆部件	Lever asm, rear	1
59	GH593	抬压脚拉杆	Presser bar lifting rod	1
60	GS026	抬压脚后拉杆轴位螺钉	Hinge screw D=7.24 H=3.3	1
61	GX589	抬压脚拉杆销	Tripping lever hinge pin	1
62	GS04	拉杆销螺钉	Screw 15/64-28 L=10.5	1
63	GR3520	抬压脚拉杆	Presser bar lifting lever	1
64	GS0618	拉簧下螺钉	Suspension screw	1
65	GW445	抬压脚拉杆拉簧	Presser foot lifting spring	1
66	GS0619	拉簧上螺钉	Suspension screw	1
67	GS0620	抬压脚拉杆定位螺钉	Lifting Lever stopper	1



## 5. 针杆摆动架分组件

## 5. Needle bar frame components

序号 Ref.No.	件号 Part No.	名 称 Description	数量 Amt.
1	GZ450/4	摆轴部件 ..... Framar rock shaft crank asm., front	
2	GR3521	针杆连接柱 ..... Stud	1
3	GL15	针杆连接柱螺母 ..... Nut 15/64-28	1
4	GU181	针杆连接柱滑块 ..... Needle bar connection slide block	1
5	GO505/3	摆轴前轴套部件 ..... Bushing	1
6	GR3522	摆轴前轴套油线 ..... Oil wick	1
7	GR3523	油线夹紧环 ..... Rubber ring	1
8	GS04	摆轴前轴套螺钉 ..... Screw 15/64-28 L=10.5	1
9	GO507	摆轴后轴套 ..... Bushing, rear	1
10	GS04	摆轴后轴套螺钉 ..... Screw 15/64-28 L=10.5	1
11	GR3524	摆轴后轴套油线 ..... Oil felt	1
12	GH595	摆轴后曲柄 ..... Frame rock shaft crank asm., rear	1
13	GS091	摆轴后曲柄螺钉 ..... Screw 15/64-28 L=12	1
14	GR3525	摆轴后曲柄油线 ..... Oil wick	1
15	GR3526	针杆摆动叉 ..... Needle bar pitman	1
16	GS0621	摆动叉连杆销螺钉 ..... Screw 11/64-40 L=12.0	1
17	GL31	摆动叉连杆销螺母 ..... Nut 11/64-40	1
18	GS0622	摆动叉连接螺钉 ..... Hinge screw D=7.94 H=8	1
19	GL0117	摆动叉连接螺母 ..... Nut 1/4-24	1
20	GR3527	摆动叉导架 ..... Rock shaft connection guide	1
21	GS0623	摆动叉导架螺钉 ..... Screw 11/64-40 L=16.0	2
22	GT201/5	针杆摆动凸轮部件 ..... Needle driving gear asm.	1
23	GR3528	摆动凸轮挡圈 ..... Thrust collar asm. D=9.53 W=10	2
24	GS0614	挡圈定位螺钉 ..... Screw 15/64-28 L=11.0	1
25	GS48	挡圈螺钉 ..... Screw 3/16-28 L=7	3
26	GZ452/2	摆动凸轮轴部件 ..... Knife driving shaft asm.	1
27	GS0614	摆动凸轮轴螺钉 ..... Screw 15/64-28 L=11.0	1
28	GR1462	摆动凸轮轴盲孔塞 ..... Rubber plug	1
29	GC206	针杆摆动小齿轮 ..... Pinion	1
30	GS39	针杆摆动小齿轮螺钉 ..... Screw 1/4-40 L=6	2
31	GR3530	针杆摆动架 ..... Needle bar frame	1
32	GX584	针杆摆动架销 ..... Hinge stud	1
33	GS05 →	针杆摆动架销螺钉 <i>GS04</i> ..... Screw 15/64-28 L=11	1
34	GR3531	针杆油毡 ..... Rock shaft connection guide	2
35	GR3532	针杆上油毡夹 ..... Oil felt	1
36	GR3533	针杆下油毡夹 ..... Oil felt retainer, lower	1
37	GS0625	针杆油毡夹螺钉 ..... Screw 9/64-40 L=5.0	2
38	GR3534	针杆油线 ..... Oil wick	1
39	GZ454	针杆连接轴 ..... Needle bar connection	1
40	GS0100	针杆连接轴螺钉 ..... Screw 9/64-40 L=8.5	1
41	GZ455	针杆 ..... Needle bar	1
42	GR3535	针杆过线钩 ..... Needle bar bobbin thread guide	1
43	N1955-01	机针 ..... Needle #12	1
44	GS071	支针螺钉 ..... Screw 1/8-44 L=4.5	1
45	GR3536	针杆摆动架定位架 ..... Position bracket	1
46	GS0611	定位架螺钉 ..... Screw 11/64-40 L=8	2

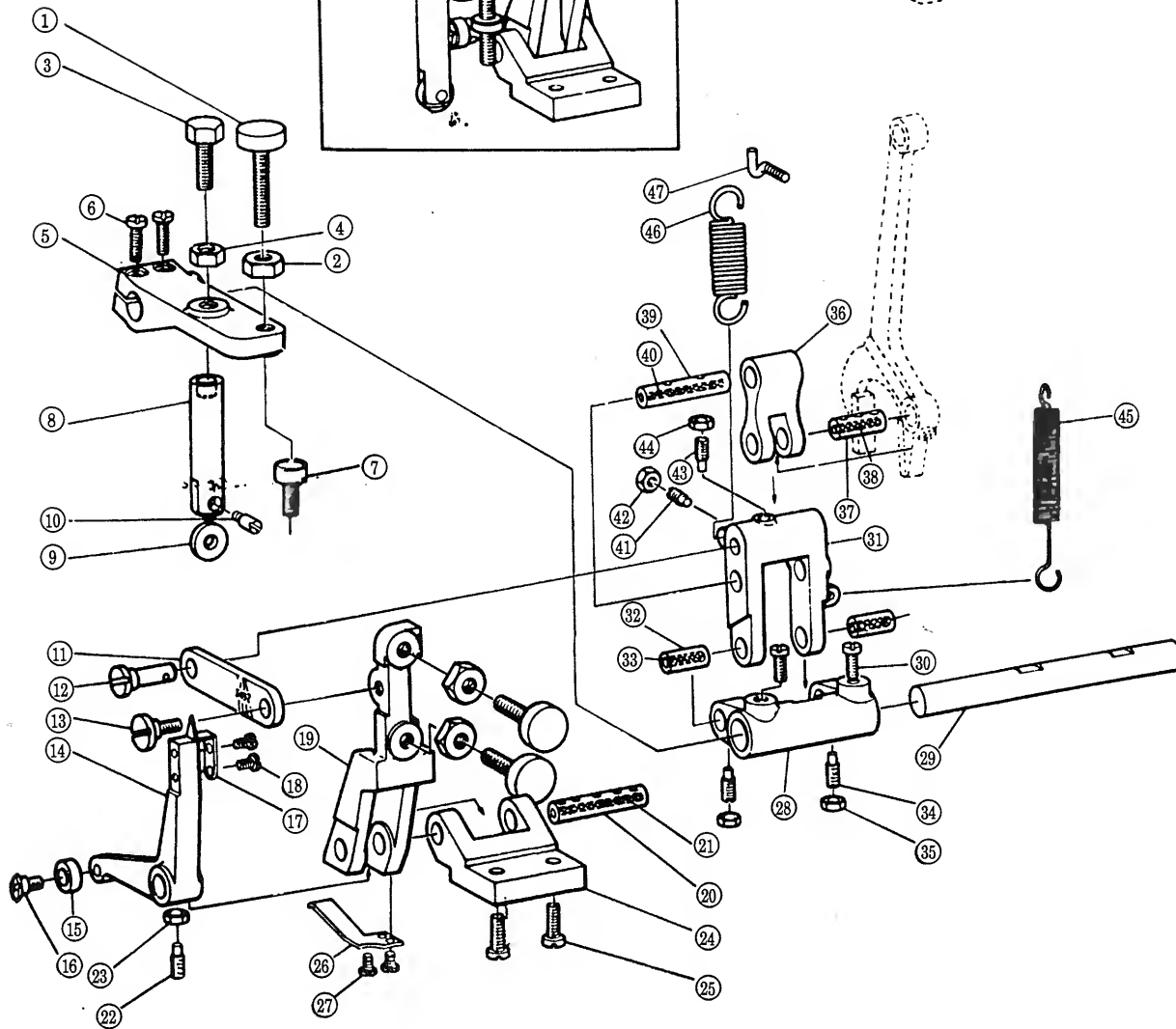
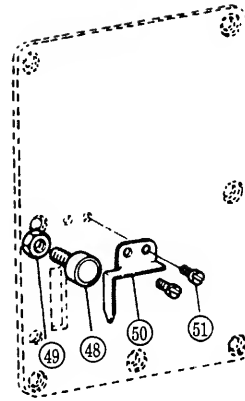
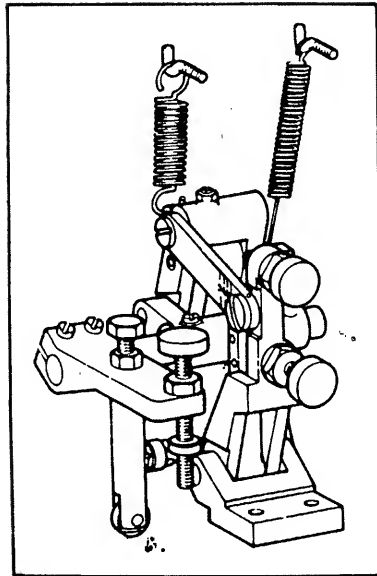


## 6、横列套结调整分组件

## 6.Overedging width adjusting components

序号	件号	名称	数量
Ref.No.	Part No.	Description	Amt.
1	GS0626	横列套结调整长螺钉	3
2	GL0118	横列套结调整螺母	3
3	GS0627	横列套结调整短螺钉	1
4	GL0119	横列套结调整小螺母	1
5	GH596	针摆复位杆	1
6	GS049	复位杆螺钉	2
7	GS0628/2	复位杆限位螺钉部件	1
8	GH597/4	针摆顶杆部件	1
9	GU212	顶杆滚柱	1
10	GS0630	顶杆滚柱轴位螺钉	1
11	GR3538	调节杆连接板	1
12	GX591	调节杆连接板销	1
13	GS0631	调节杆连接板螺钉	1
14	GH599	套结曲柄	1
15	GU213	套结曲柄滚柱	1
16	GS0632	套结曲柄滚柱轴位螺钉	1
17	GR3539	套结宽度指针	1
18	GS071	指针螺钉	2
19	GH600	调节杆	1
20	GZ456	调节杆轴	1
21	GR3540	调节杆轴油线	1
22	GS0621	调节杆轴螺钉	1
23	GL31	调节杆轴螺母	1
24	GR3541	调结杆座	1
25	GS091	调结杆座螺钉	2
26	GW446	套结曲柄复位簧	1
27	GS071	复位簧螺钉	2
28	GR3542	针摆复位连杆座	1
29	GZ457	针摆复位杆轴	1
30	GS081	针摆复位杆轴螺钉	2
31	GH601	复位杆连杆	1
32	GX592	复位杆连杆销	2
33	GR3543	复位杆连杆销油线	2
34	GS0621	复位杆连杆销螺钉	2
35	GL31	复位杆连杆销螺母	2
36	GH602	摆动叉连杆	1
37	GX593	摆动叉连杆短销	1
38	GR3544	摆动叉连杆短销油线	1
39	GX594	摆动叉连杆长销	1
40	GR3545	摆动叉连杆长销油线	1
41	GS0621	摆动叉连杆长销螺钉	1
42	GL31	摆动叉连杆长销螺母	1
43	GS0621	调节杆连接板销螺钉	1
44	GL31	调节杆连接板销螺母	1
45	GW447	针摆复位杆长弹簧	1
46	GW448	针摆复位杆短弹簧	1
47	GR3546	弹簧吊钩螺钉	2
48	GS0628/2	调节杆限位螺钉部件	1
49	GL15	调节杆限位螺母	1
50	GR3547	横列宽度指针	1
51	GS071	横列宽度指针螺钉	2

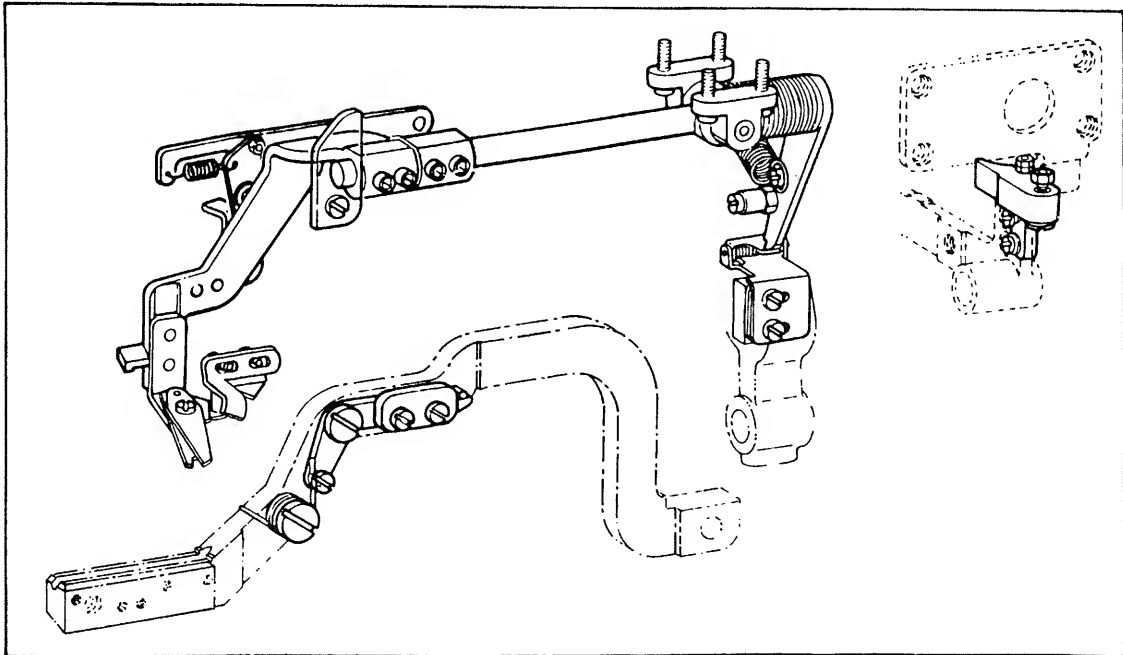
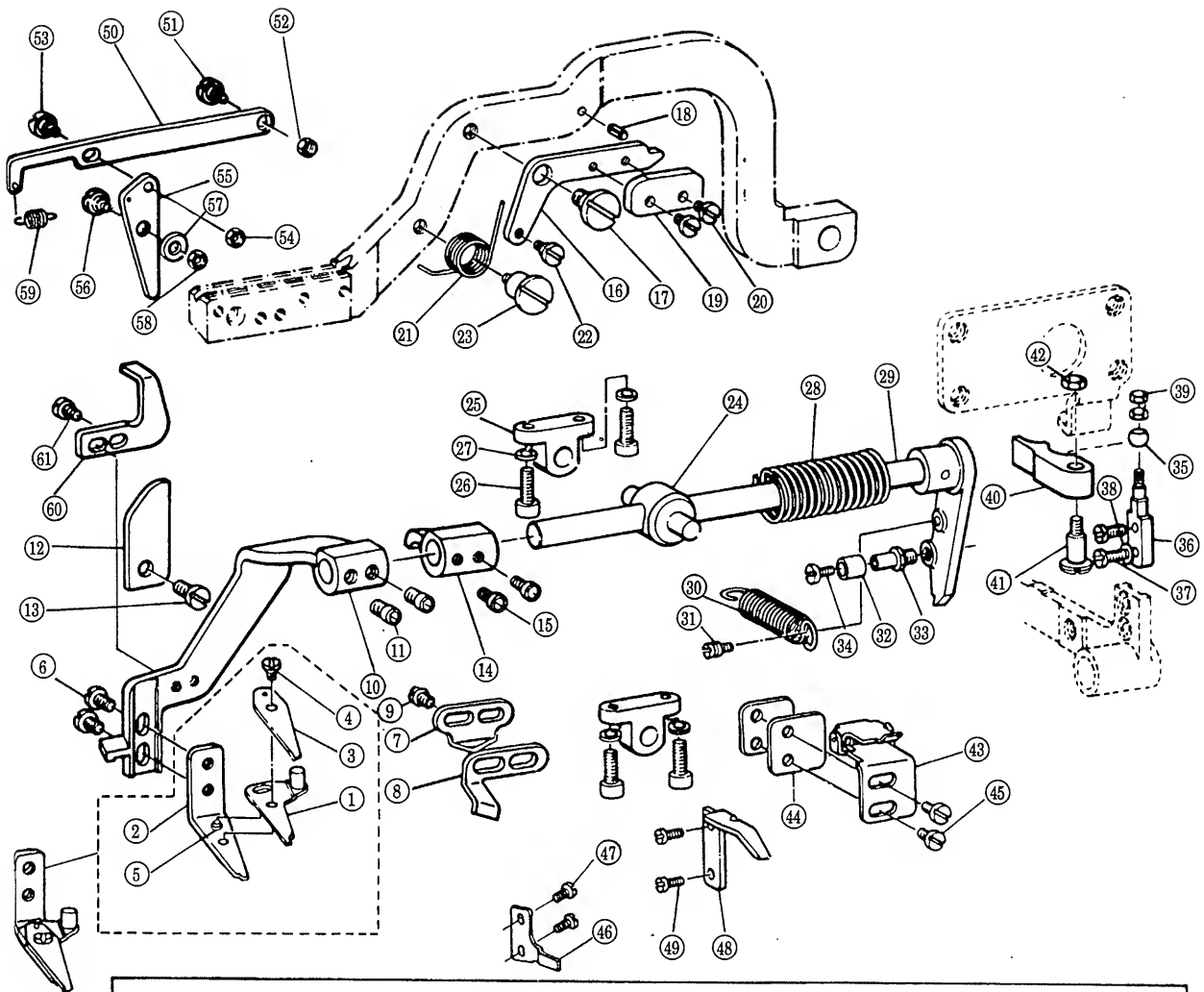




## 7、面线剪刀分组件

## 7. Needle thread trimmer components

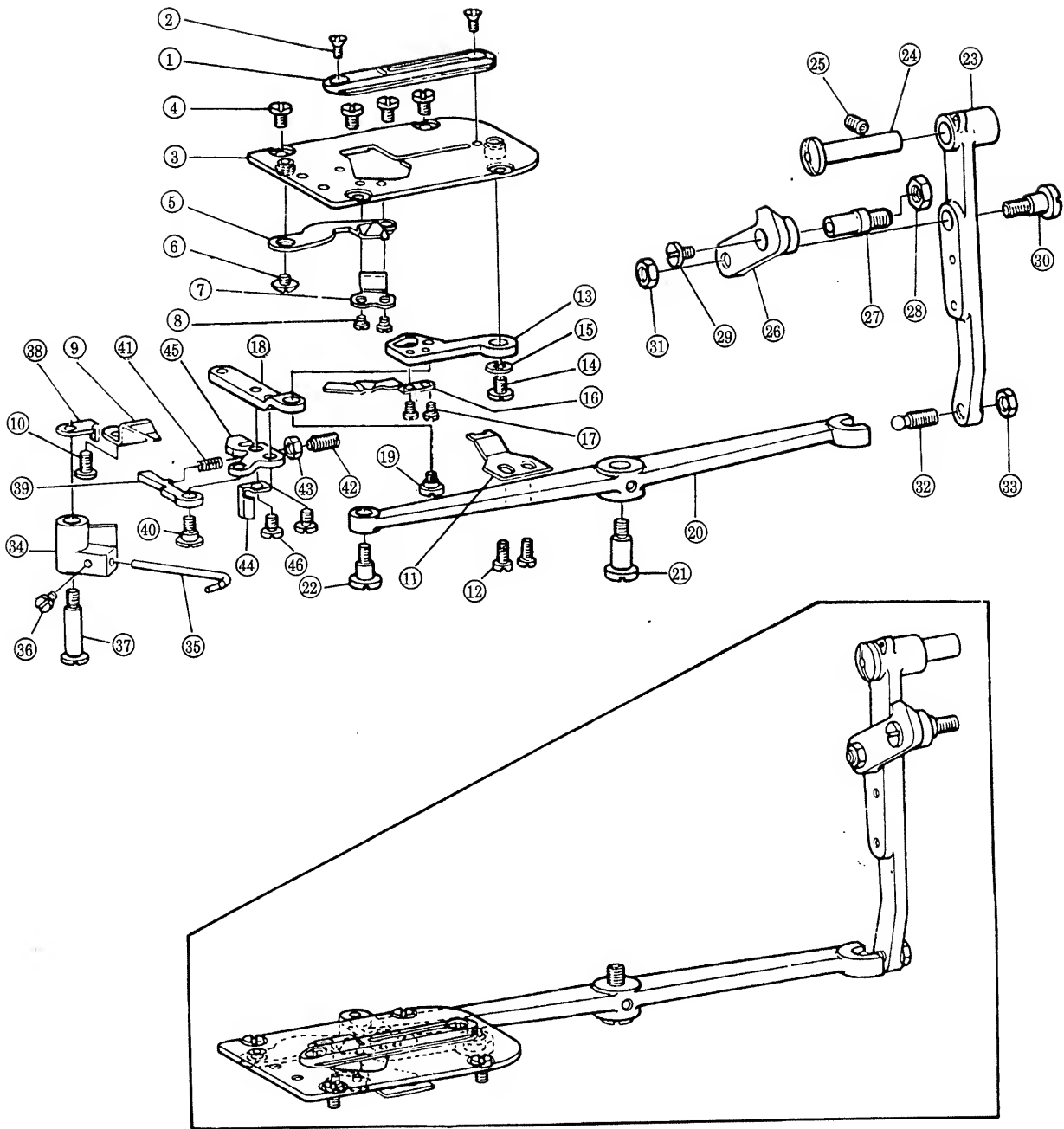
序号 Ref.No.	件号 Part No.	名 称 Description	数量 Amt.
1	GR3549/2	面线剪刀上刀部件.....	1
2	GR3551	面线剪刀下刀.....	1
3	GW449	面线剪刀簧.....	1
4	GS0633	面线剪刀簧螺钉.....	1
5	GX595	面线剪刀簧销.....	1
6	GS0158	面线剪刀紧固螺钉.....	2
7	GR3552	开剪控制板.....	1
8	GR3553	闭剪控制板.....	1
9	GS0609	控制板螺钉.....	1
10	GR3554	面线剪刀摆动架.....	1
11	GS0634	摆动架螺钉.....	2
12	GR3555	面线剪刀轴导板.....	1
13	GS0635	导板螺钉.....	1
14	GR3556	面线剪刀托架.....	1
15	GS0634	面线剪刀托架螺钉.....	2
16	GR3557	传动凸块安装板.....	1
17	GS0636	安装板轴位螺钉.....	1
18	GX596	安装板限位销.....	1
19	GR3558	传动凸块.....	1
20	GS0637	传动凸块螺钉.....	2
21	GW450	传动凸块复位簧.....	1
22	GX597	传动凸块复位簧销.....	1
23	GS0638	复位簧轴位螺钉.....	1
24	GX598	面线剪刀十字销.....	1
25	GR3559	十字销座.....	2
26	GS0639	十字销座螺钉.....	4
27	GR3560	十字销座螺钉垫圈.....	4
28	GW451	面线剪刀复位簧.....	1
29	GZ458/3	面线剪刀轴部件.....	1
30	GW452	面线剪刀复位位簧.....	1
31	GS0640	拉簧螺钉.....	1
32	GU214	面线剪刀起动滚柱.....	1
33	GX599	起动滚柱销.....	1
34	GS0641	起动滚柱销螺钉.....	1
35	GU163	剪面线滚柱.....	1
36	GS0642	滚柱螺栓.....	1
37	GS0609	滚柱螺栓螺钉.....	2
38	GR1528	滚柱螺栓垫圈.....	1
39	GL0120	剪面线滚柱螺母.....	2
40	GR3561	剪面线滚柱垫板.....	1
41	GS0643	垫板轴位螺钉.....	1
42	GL31	垫板螺母.....	1
43	GR3562/4	线头控制板部件.....	1
44	GR3564	控制板垫片.....	2
45	GS0609	线头控制板螺钉.....	2
46	GR3565	控制板触杆.....	1
47	GS0637	触杆螺钉.....	2
48	GR3566	控制板压板.....	1
49	GS0637	压板螺钉.....	2
50	GH604	面线剪刀限位连杆.....	1
51	GS048	限位连杆后轴位螺钉.....	1
52	GL20	后轴位螺母.....	1
53	GS0587	限位连杆前轴位螺钉.....	1
54	GL31	前轴位螺母.....	1
55	GR3567	限位杠杆.....	1
56	GS0644	限位杠杆轴位螺钉.....	1
57	GR3568	限位杠杆轴位螺钉垫圈.....	1
58	GL31	限位杠杆轴位螺母.....	1
59	GW454	限位杠杆拉簧.....	1
60	GR3569	面线剪刀限位板.....	1
61	GS0609	限位板螺钉.....	2



## 8、底线剪刀分组件

## 8.Bobbin thread trimmer components

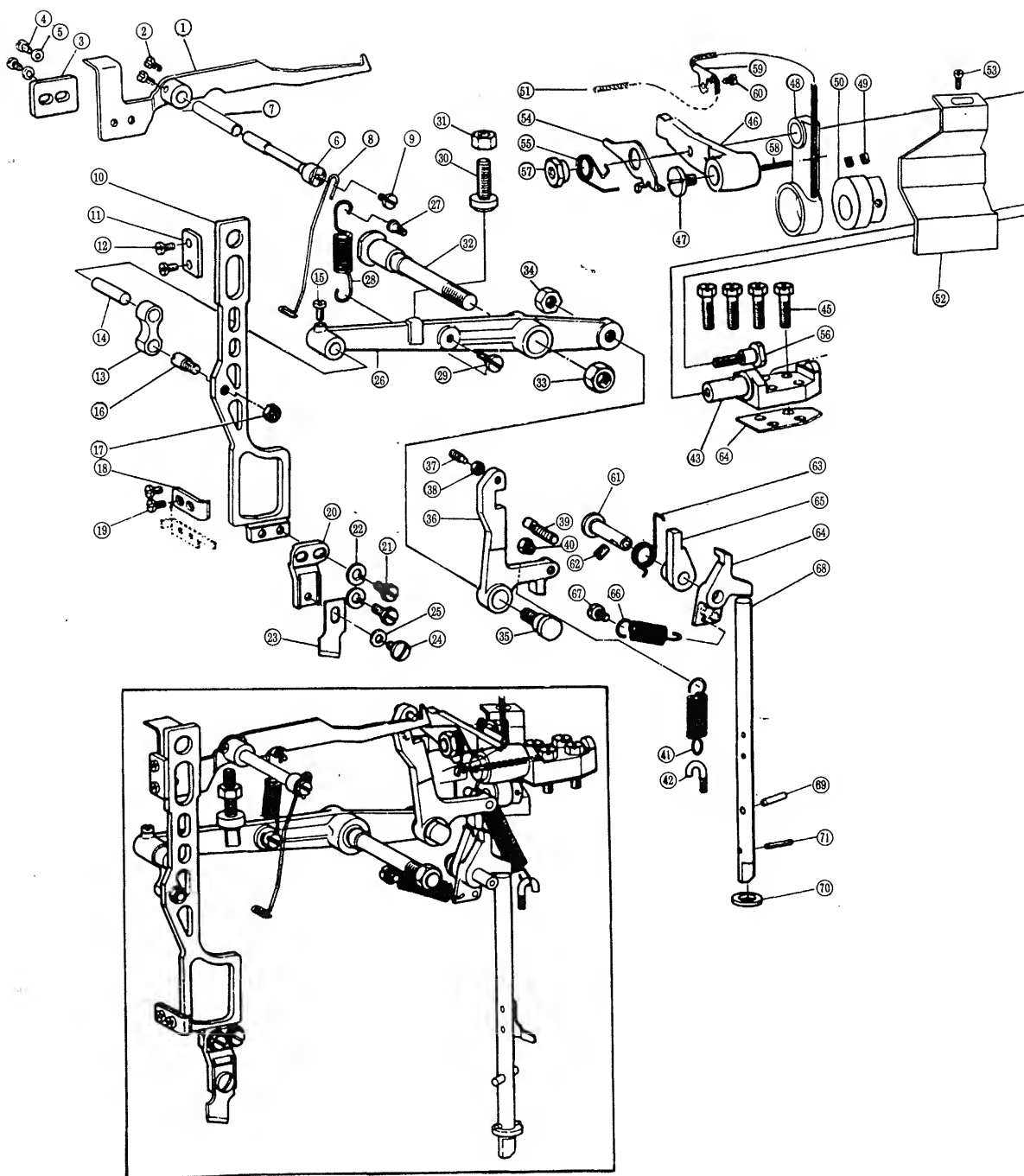
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1	GM346	针板	1
2	GS0645	针板螺钉	2
3	GR3570/3	针板座部件	1
4	GS0646	针板座螺钉	4
5	GR3574/2	剪底线上刀片部件	1
6	GS0647	上刀片螺钉	1
7	GR3576	剪底线下刀片	1
8	GS0648	下刀片螺钉	2
9	GR3577	底线上刀片托板	1
10	GS0609	托板螺钉	1
11	GW455	底线头夹簧	1
12	GS0646	夹簧螺钉	2
13	GR3578	剪底线传动杆	1
14	GS0649	传动杆螺钉	1
15	GR3579	传动杆螺钉垫圈	1
16	GR3580	底线拉出杆	1
17	GS0650	拉出杆螺钉	2
18	GH605	剪底线连杆	1
19	GS0651	连杆螺钉	1
20	GR3581	剪底线杠杆	1
21	GS0652	杠杆轴位螺钉	1
22	GS0653	杆杆螺钉	1
23	GR3582	剪底线拨杆	1
24	GX584	拨杆销	1
25	GS48	拨杆销螺钉	1
26	GH606	拨杆连杆	1
27	GX600	拨杆连杆螺钉销	1
28	GL9	螺钉销螺母	1
29	GS0649	拨杆连杆螺钉	1
30	GS0654	拨杆连杆连接螺钉	1
31	GL15	连接螺钉螺母	1
32	GS0655	拨杆球螺钉	1
33	GL15	拨杆球螺母	1
34	GR3584	挡线器座	1
35	GZ460	梭心压杆	1
36	GS0656	梭心压杆螺钉	1
37	GS0657	挡线器座轴位螺钉	1
38	GR3585	挡线器座压力限位板	1
39	GR3586	挡线器座顶板	1
40	GR3587	顶板轴位螺钉	1
41	GW456	顶板簧	1
42	GS0658	顶板螺钉	1
43	GL20	顶板螺钉螺母	1
44	GR3588	挡线器座安全限位板	1
45	GR3589	顶板安装板	1
46	GS0158	安装板螺钉	2



## 9、切刀分组件

## 9. Knifiebar components

序号 Ref.No.	件号 Part No.	名称	Description	数量 Amt.
1	GR3590/2	停刀杆部件	Knife stop lever	1
2	GS082	停刀杆套螺钉	Screw 11/64-40 L=4.8	2
3	GR3592	停刀杆平衡块	Knife stop lever bracket	1
4	GS092	平衡块螺钉	Screw 11/64-40 L=7	2
5	GR1528	平衡块螺钉垫圈	Washer 4.8×8.4×0.8	2
6	GZ461	停刀杆轴	Knife stop lever hinge stud	1
7	GO509	停刀杆轴轴套	Knife stop lever shaft guide	1
8	GW457	勾线簧	Thread check wire	1
9	GS0609	勾线簧螺钉	Screw 11/64-40 L=8.2	1
10	GR3593	切刀杆	Knife bar	1
11	GR3594	切刀杆压板	Knife bar guide bracket	1
12	GS0106	压板螺钉	Screw 11/64-40 L=7	2
13	GH607	切刀杆连杆	Knife bar connecting link	1
14	GX601	切刀杆连杆销	Hinge stud	1
15	GS0659	连杆销螺钉	Screw 11/64-40 L=8.0	1
16	GS0660	切刀杆轴位螺钉	Hinge screw	1
17	GL0121	切刀杆轴位螺母	Nut 1/4-40	1
18	GR3595	切刀杆定位架	Knife bar position bracket	1
19	GS0661	定位架螺钉	Screw 11/64-40 L=7.5	2
20	GR3596	刀架	Knife holder	1
21	GS0662	刀架螺钉	Screw 1/4-40 L=11	2
22	GR3597	刀架弹簧垫圈	Spring washer 6.5×11×1.3	2
23	GR3598	刀片(1371A1)	Knife 1/2"(for 1371A1)	1
	GR3599G	刀片(1371A2)	Knife 1"(for 1371A2)	1
	GR3599H	刀片(1371A3)	Knife 5/4"(for 1371A3)	1
24	GS051	刀片螺钉	Screw 3/16-32 L=6.5	1
25	GR3600	刀片螺钉垫圈	Washer 5×10.5×1	1
26	GR3601	切刀杠杆	Knife bar driving lever	1
27	GS0663	切刀杠杆弹簧上螺钉	Hinge screw D=5.5 H=5	1
28	GW458	切刀杠杆弹簧	Spring	1
29	GS0664	切刀杠杆弹簧下螺钉	Hinge screw D=7.9 H=2.0	1
30	GS0665/2	切刀杠杆停刀螺钉部件	Knife bar driving lever asm.	1
31	GL0122	停刀螺钉螺母	Nut 1/16-18	1
32	GZ462	切刀杠杆轴	Knife bar driving lever shaft	1
33	GS0667	切刀杠杆轴螺母	Nut 3/8-28	1
34	GL0123	锁紧杠杆螺母	Nut 5/16-24	1
35	GS0668	锁紧杠杆螺钉	Hinge screw D=11.11 H=9.0	1
36	GR3603	锁紧杠杆	Knife bar driving lever bell crank	1
37	GS0669	锁紧杠杆停刀螺钉	Screw 11/64-40 L=15.5	1
38	GL31	锁紧杠杆停刀螺母	Nut 11/64-40	1
39	GS0670	锁紧杠杆偏心螺钉	Pin	1
40	GL0124	锁紧杠杆偏心螺母	Nut 15/64-28	1
41	GW459	锁紧杠杆弹簧	Tension spring	1
42	GS0671	锁紧杠杆弹簧钩螺钉	Suspension screw	1
43	GH608	切刀摆动杆座	Knife bar driving crank shaft	1
44	GR3604	切刀摆动杆座垫	Spacer	1
45	GS0590	切刀摆动杆座螺钉	Screw 15/64-28 L=20.5	4
46	GH609	切刀摆动杆	Knife bar driving crank	1
47	GS0195	切刀摆动杆螺钉	Screw 1/4-24 L=9.5	1
48	GH610	偏心连杆	Knife bar driving connecting rod	1
49	GS033	偏心轮螺钉	Screw 1/4-40 L=8	2
50	GT203	偏心轮	Knife bar driving eccentric	1
51	GR3605	偏心轮油线	Oil wick	1
52	GR3606	偏心轮挡油板	Arm oil shield	1
53	GS0106	偏心轮挡油板螺钉	Screw 11/64-40 L=7	1
54	GR3607	切刀摆动杆锁紧板	Latch	1
55	GW460	锁紧板弹簧	Tension spring	1
56	GS0668	偏心连杆螺钉	Hinge screw D=11.11 H=9.0	1
57	GL0125	偏心连杆螺母	Knife bar driving crank nut	1
58	GR3608	切刀摆动杆座油线	Oil wick	1
59	GR3609	切刀摆动杆油线火	Oil wick holder	1
60	GS0588	油线夹螺钉	Screw 9/64-40 L=5	1
61	GX584	切刀摆动块销	Hing stud	1
62	GS48	切刀摆动块销螺钉	Screw 15/64-28 L=7	1
63	GW461	摆动块扭簧	Tension spring	1
64	GR3610/2	切刀主动摆动块部件	Ratchet pawl	1
65	GR3612	切刀摆动块	Ratchet pawl	1
66	GW462	切刀主动摆动块拉簧	Tension spring	1
67	GS0672	拉簧螺钉	Hinge screw D=5.30 H=2.2	1
68	GH611	切刀顶杆	Driving rod	1
69	GH612	切刀顶杆上定位销	Positioning pin	1
70	GR3613	切刀顶杆缓冲垫圈	Thrust washer	1
71	GX603	切刀顶杆下定位销	Spring pin 3×18	1

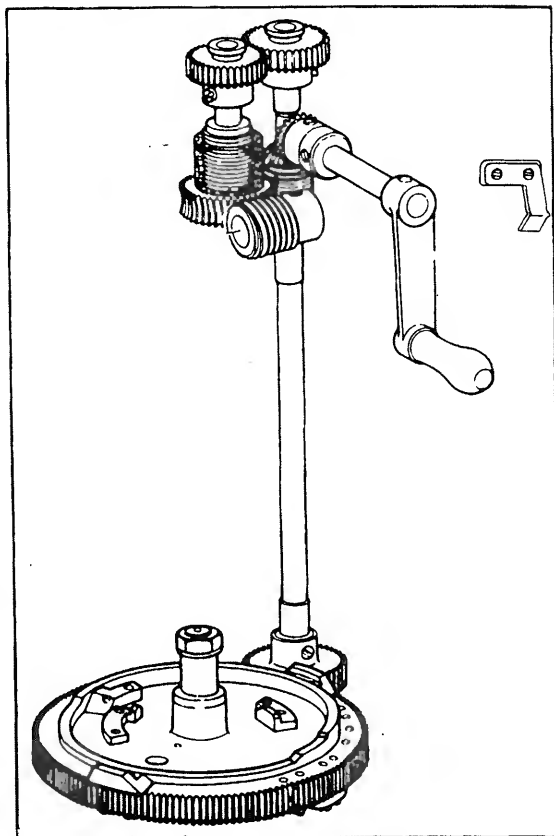
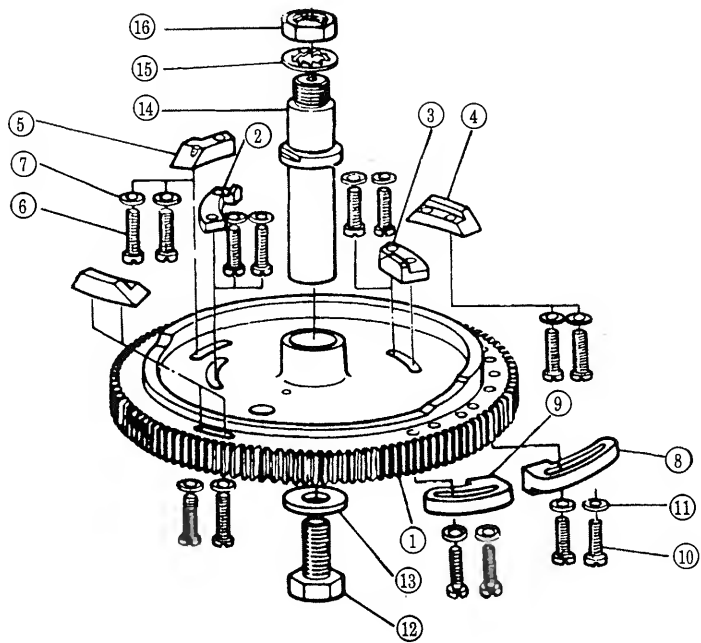
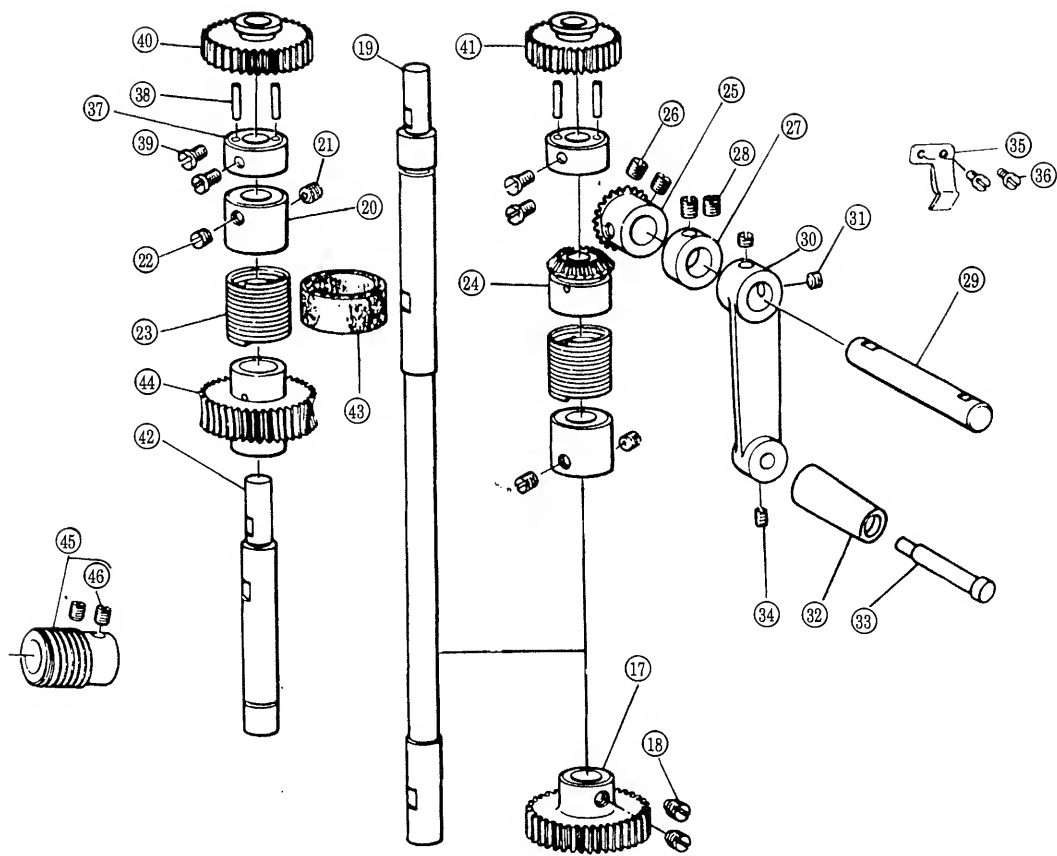


## 10、送料凸轮分组件

## 10. Feed cam and tripping Segment Components

序号	件号	名称	数量
Ref.No.	Part No.	Description	Amt.
1	GT205	送料凸轮.....	Feed cam ..... 1
2	GT206	前松线凸块.....	Tension release trippint segment..... 1
3	GT207	后松线凸块.....	Tension release tripping segment..... 1
4	GT208	套结凸块.....	Bar tripping segment No.2..... 2
5	GT209	切刀凸块.....	Knife tripping segment..... 1
6	GS0673	凸块螺钉.....	Screw 11/64-40 L=16..... 10
7	GR1528	凸块垫圈.....	Washer 4.8×8.4×0.8..... 10
8	GT210	变速凸块.....	Low speed cam ..... 1
9	GT211	止动凸块.....	Stopper cam ..... 1
10	GS079	变速、止动凸块螺钉.....	Screw 11/64-40 L=14..... 4
11	GR1528	变速、止动凸块垫圈.....	Washer 4.8×8.4×0.8..... 4
12	GS0674	送料凸轮紧固螺钉.....	Screw 3/8-18 L=15..... 1
13	GR3614	送料凸轮垫圈.....	Washer 9.8×24.0×2.6..... 1
14	GZ463	送料凸轮轴.....	Feed cam shaft ..... 1
15	GR3615	凸轮轴弹性垫圈.....	Thrust washer ..... 1
16	GL0126	凸轮轴螺母.....	Nut 1/2-20..... 1
17	GC207	送料凸轮传动齿轮.....	Feed cam driving gear asm..... 1
18	GS39	传动齿轮螺钉.....	Screw 1/4-40 L=6..... 2
19	GZ464	送料凸轮传动轴.....	Feed cam driving shaft ..... 1
20	GR3616	离合紧圈.....	Clutch collar asm..... 2
21	GS0249	离合紧圈螺钉.....	Screw 1/4-40 L=4.2..... 2
22	GS39	离合紧圈定位螺钉.....	Screw 1/4-40 L=6..... 2
23	GW463	离合簧.....	Clutch spring..... 2
24	GC208	传动轴伞齿轮.....	Handle crank bevel gear, left..... 1
25	GC209	手柄伞齿轮.....	Handle crank bevel gear asm., right..... 1
26	GS39	手柄伞齿轮螺钉.....	Screw 1/4-40 L=6..... 2
27	GR3617	手柄伞齿轮挡圈.....	Thrust collar asm. D=11.11 W=10..... 1
28	GS0597	手柄伞齿轮挡圈螺钉.....	Screw 1/4-40 L=4.5..... 2
29	GH613	手柄曲柄轴.....	Handle crank shaft..... 1
30	GH614	手柄曲柄.....	Handle crank..... 1
31	GS041	手柄曲柄螺钉.....	Screw 15/64-28 L=4.7..... 2
32	GR3618	手柄.....	Handle shaft ..... 1
33	GZ465	手柄轴.....	Handle shaft ..... 1
34	GS038	手柄轴螺钉.....	Screw 3/16-32 L=6..... 1
35	GW464	手柄限位簧.....	Hand stop latch..... 1
36	GS0106	手柄限位簧螺钉.....	Screw 11/64-40 L=7..... 2
37	GR3620	交换齿轮挡圈.....	Spur gear bushing asm..... 2
38	GX604	交换齿轮定位销.....	Spur gear bushing pin..... 4
39	GS0675	交换齿轮挡圈螺钉.....	Screw 3/16-28 L=9..... 4
40	GC210	交换齿轮(123).....	Spur gear..... 1
41	GC211	交换齿轮(152).....	Spur gear..... 1
42	GZ466	蜗轮轴.....	Feed cam driving worm wheel shaft..... 1
43	GR3621	蜗轮轴油毡圈.....	Oil felt..... 1
44	GC218	蜗轮.....	Feed cam driving worm wheel..... 1
45	GC219	蜗杆.....	Worm asm..... 1
46	GS39	蜗杆螺钉.....	Screw 1/4-40 L=6..... 2

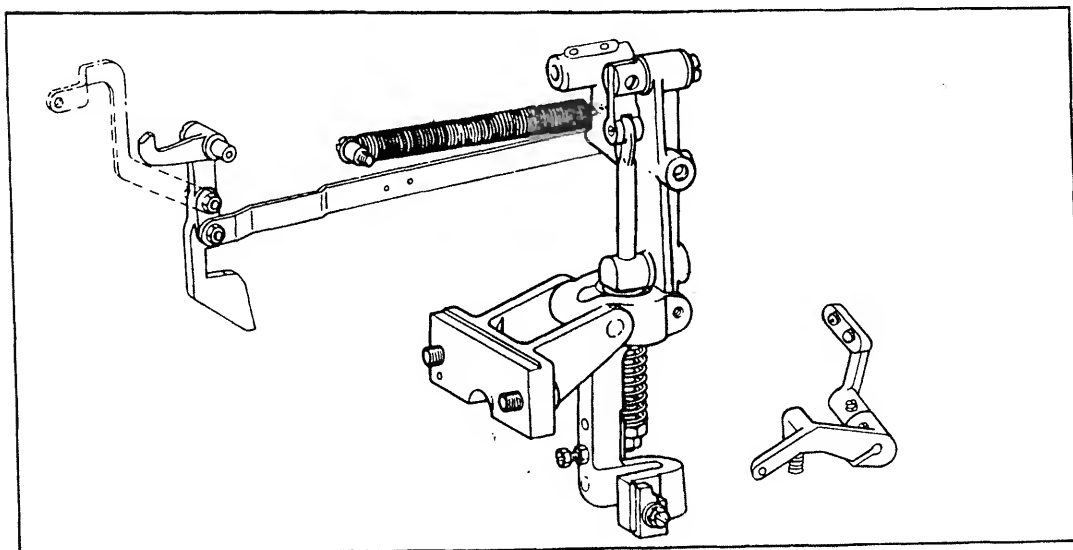
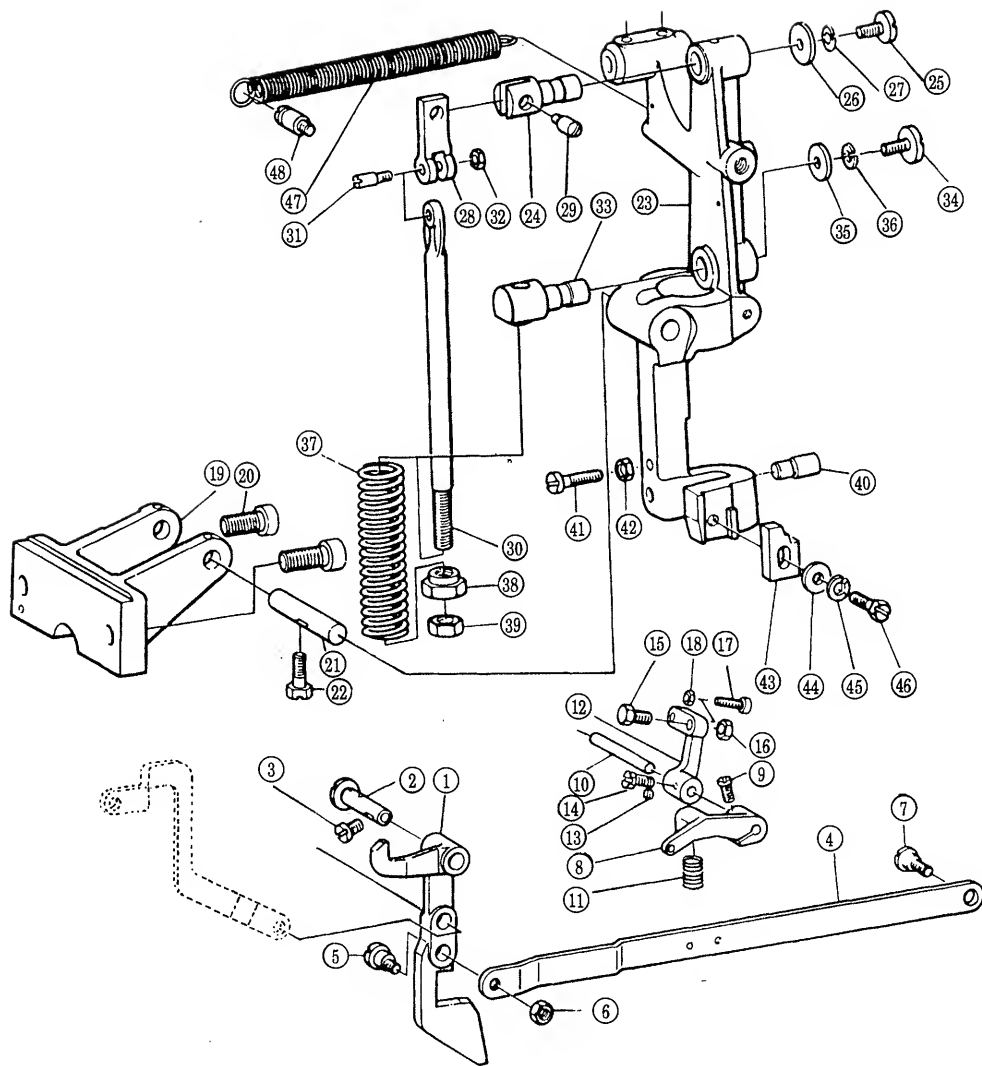




## 11、启动止动分组件

## 11.Stop-motion components

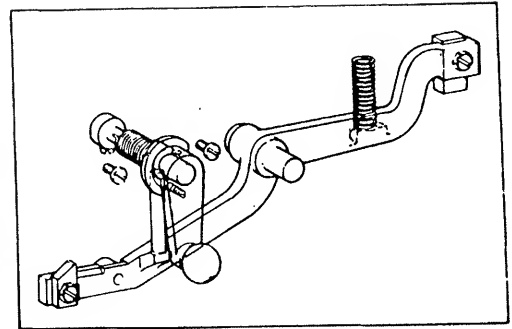
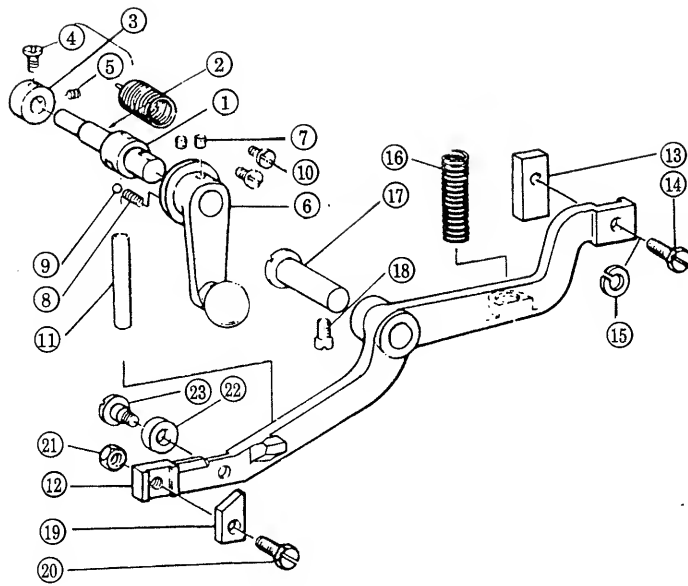
序号 Ref.No.	件号 Part No.	名称	Description	数量 Amt.
1	GH615	启动杆	Starting link	1
2	GX584	启动杆销	Hinge stud	1
3	GS081	启动杆销螺钉	Screw 15/64-28 L=9	1
4	GH616	启动推杆	Starting link driving rod	1
5	GS0676	推杆偏心螺钉	Hinge screw	1
6	GL15	推杆偏心螺钉螺母	Nut 15/64-28	1
7	GS0677	推杆螺钉	Hinge screw D=7.94 H=4.5	1
8	GR3622	启动杠杆	Starting lever	1
9	GS091	启动杠杆螺钉	Screw 15/64-28 L=12	1
10	GX605	启动杠杆销	Starting link shaft	1
11	GW465	启动杠杆压簧	Starting lever pressure spring	1
12	GR3623	启动架	Starting link	1
13	GS48	启动架螺钉	Screw 15/64-28 L=7	1
14	GS0678	启动架定位螺钉	Screw 15/64-28 L=8	1
15	GS0627	启动架启动螺钉	Screw 15/64-18 L=19	1
16	GL0119	启动架启动螺母	Nut 5/16-18	1
17	GS0679/2	启动架限位螺钉部件	Stop screw asm.	1
18	GL15	启动架限位螺母	Nut 15/64-28	1
19	GR3624	上轴止动架支座	Stop motion lever bracket	1
20	GS0681	上轴止动架支座螺钉	Screw 3/8-18 L=22.0	2
21	GX606	上轴止动架销	Pin	1
22	GS0616	上轴止动架销螺钉	Screw 15/64-28 L=15.5	1
23	GR3625	上轴止动架	Stop motion lever	1
24	GX607	上轴止动架上连接销	Stop link hinge stud	1
25	GS0682	上连接销螺钉	Screw 15/64-28 L=13.0	1
26	GR3626	上连接销垫圈	Washer 6.1 × 8.5 × 2	1
27	GR3627	上连接销弹簧垫圈	Washer	1
28	GR3628	上轴止动杆连接块	Stop link	1
29	GS0683	连接块螺钉	Stop link connecting screw	1
30	GR3629	上轴止动杆	Stop link rod	1
31	GS0684	上轴止动杆螺钉	Stop link rod hinge screw	1
32	GL19	上轴止动杆螺母	Nut 3/16-32	1
33	GX608	上轴止动杆下连接销	Stop link rod hinge stud	1
34	GS0682	下连接销螺钉	Screw 15/64-28 L=13.0	1
35	GR3626	下加接销垫圈	Washer 6.1 × 18.5 × 2	1
36	GR3627	下连接销弹簧垫圈	Washer	1
37	GW466	上轴止动杆压簧	Stop link rod pressure spring	1
38	GL0127	上轴止动杆压簧紧固螺母	Nut, for stop link rod	1
39	GL0128	上轴止动杆压簧螺母	Nut 3/8-18	1
40	GH617	启动顶杆	Stop pin	1
41	GS0108	上轴止动杆架限位螺钉	Screw 15/64-28 L=30	1
42	GL21	上轴止动杆架限位螺母	Nut 15/64-28	1
43	GR3630	止动分档块	Latch,	1
44	GR3631	止动分档块垫圈	Washer 6.1 × 15.2 × 2.5	1
45	GR3627	止动分档块弹簧垫圈	Washer	1
46	GS0590	止动分档块螺钉	Screw 15/64-28 L=20.5	1
47	GW467	拉簧	Tension spring	1
48	GS0619	拉簧螺钉	Suspension screw	1



## 12、手动停车分组件

## 12.Tripping lever components

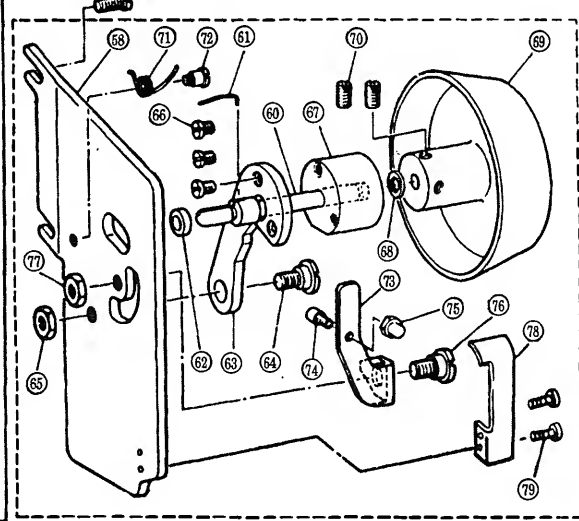
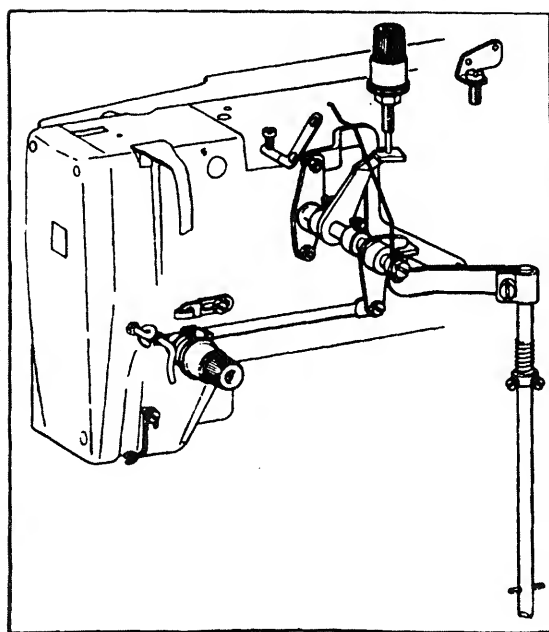
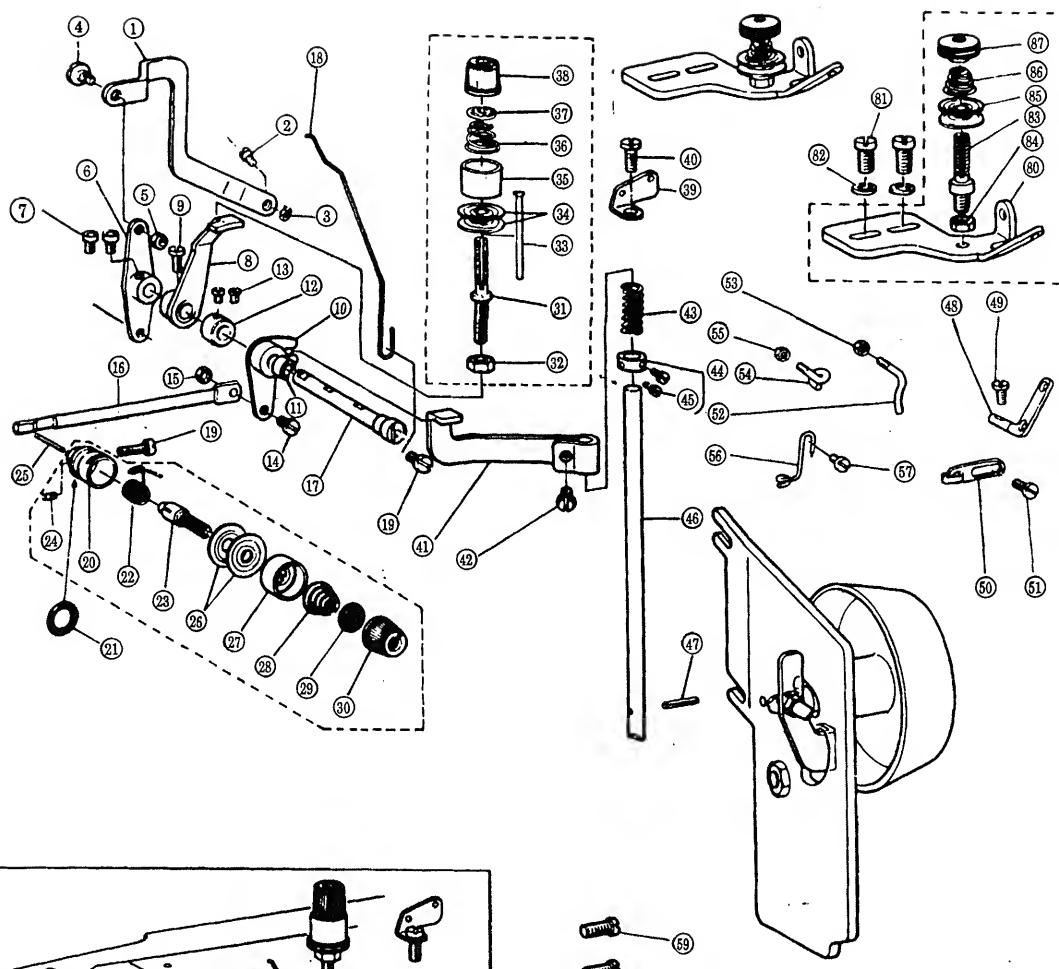
序号	件 号	名 称	数量
Ref.No.	Part No.	Description	Amt.
1	GZ467	停车手柄轴·····Hand stop crank shaft·····	1
2	GW468	停车手柄轴扭簧·····Crank shaft tension spring·····	1
3	GR1519	停车手柄轴挡圈·····Thrust collar asm. D=7.94 W=10·····	1
4	GS092	手柄轴挡圈长螺钉·····Screw 11/64-40 L=7·····	1
5	GS013	手柄轴挡圈短螺钉·····Screw 11/64-40 L=5·····	1
6	GR3632/2	停车手柄部件·····Hand stop crank asm.·····	1
7	GS041	停车手柄螺钉·····Screw 15/64-28 L=4.7·····	2
8	GW242	手柄定位簧·····Crank shaft pressure spring·····	1
9	GO240	手柄定位滚珠·····Hand stop crank shaft-ball·····	1
10	GS030	手柄限位螺钉·····Screw 11/64-40 L=9.5·····	2
11	GX610	手柄停车销·····Hand stop rod·····	1
12	GR3636	停车杠杆·····Tripping lever·····	1
13	GR3637	停车挡块·····Latch·····	1
14	GS0590	停车挡块螺钉·····Screw 15/64-28 L=20.5·····	1
15	GR3638	停车挡块弹簧垫圈·····Spring washer 6.5×12.5×1.5·····	1
16	GW243	停车杠杆弹簧·····Tripping lever tension spring·····	1
17	GX589	停车杠杆销·····Tripping lever hinge pin·····	1
18	GS081	停车杠杆销螺钉·····Screw 15/64-28 L=9·····	1
19	GR3639	停车杠杆斜挡块·····Tripping dog·····	1
20	GS0590	斜挡块螺钉·····Screw 15/64-28 L=20.5·····	1
21	GL21	斜挡块螺母·····Nut 15/64-28·····	1
22	GU213	变速顶杆滚柱·····Roller·····	1
23	GS0632	变速顶杆滚柱轴位螺钉·····Hinge screw D=6.35 H=4.7·····	1



## 13、夹线、绕线分组件

## 13.Thread tension components

序号 Ref.No.	件号 Part No.	名称	Description	数量 Amt.
1	GH618	松线拉杆	Tension release link	1
2	GS0676	松线拉杆偏心螺钉	Hinge screw	1
3	GL15	松线拉杆偏心螺母	Nut 15/64-28	1
4	GS048	松线拉杆轴位螺钉	Hinge screw D=6.35 H=3.9	1
5	GL20	松线拉杆轴位螺母	Nut 3/16-28	1
6	GR3640/2	松线拉杆部件	Tension release lever no.1	1
7	GS083	松线拉杆螺钉	Screw 3/16-32 L=9.5	2
8	GH619/2	套结松线曲柄部件	Tension release lever	1
9	GS021	套结松线曲柄螺钉	Screw 3/16-32 L=9.5	1
10	GH620	横列松线曲柄	Tension release lever crank, no.2	1
11	GO512	横列松线曲柄轴套	Bushing	1
12	GR1519	横列松线曲柄挡圈	Thrust collar asm. D=7.94 W=10	1
13	GS092	挡圈螺钉	Screw 11/64-40 L=7	2
14	GS0685	横列松线曲柄轴位螺钉	Hinge screw D=5 H=3	1
15	GL48	横列松线曲柄轴位螺母	Nut 9/64-40	1
16	GH621	横列松线推杆	Tension release rod	1
17	GH622	松线曲柄轴	Tension release lever shaft	1
18	GR3643	拔线钢丝	Thread pulling wire	1
19	GS0609	拔线钢丝螺钉	Screw 11/64-40 L=8.2	1
20	GR3645	挑线簧调节座	Tension post socket	1
21	GR3646	挑线簧调节座O形圈	Rubber ring	1
22	GW244	挑线簧	Thread take-up spring	1
23	GS0686	横列夹线螺钉	Tension post no.3	1
24	GS016	夹线螺钉紧固螺钉	Screw 9/64-40 L=5.5	1
25	GX611	横列松线钉	Tension release pin, no.2	1
26	GR1488	横列夹松板	Tension disc	2
27	GR3647	横列夹线簧座	Tension disc presser tube	1
28	GW251	横列夹线簧	Tension spring	1
29	GR1490	横列夹线螺母定位板	Thread pulling wire	1
30	GL34/2	横列夹线螺母部件	Tension nut	1
31	GS0687	套结夹线螺钉	Tension post no.2	1
32	GL4	套结夹线螺母	Nut 1/4-24	1
33	GX612	套结夹线钉	Tension release pin no.2	1
34	GR1488	套结夹线板	Tension disc	2
35	GR3647	套结夹线簧座	Tension disc presser tube	1
36	GW470	套结夹线簧	Tension spring no.1	1
37	GR1490	套结夹线螺母定位板	Tension disc stopper	1
38	GL34/2	套结夹线螺母部件	Tension nut	1
39	GR2623	导线板	Thread guide plate	1
40	GS091	导线板螺钉	Screw 15/64-28 L=12	1
41	GR3649	松线臂	Tension release arm asm.	1
42	GS0688	松线臂螺钉	Screw 1/4-40 L=8.5	1
43	GW471	松线顶杆簧	Spring	1
44	GR3650	松线顶杆挡圈	Thrust collar asm. D=7.94 W=6	1
45	GS0689	松线顶杆挡圈螺钉	Screw 9/64-40 L=4.5	2
46	GH623	松线顶杆	Tension release rod	1
47	GX603	松线顶杆限位销	Spring pin 3 × 18	1
48	GR3651	二眼线钩	Thread eyelet	1
49	GS0106 → 28.013	二眼线钩螺钉	Screw 11/64-40 L=7	1
50	GR1483	过线钩	Frame thread guide	1
51	GS0637	过线钩螺钉	Screw 9/64-40 L=6.8	1
52	GR3652	绕线调节钩	Tension thread guide	1
53	GL48	绕线调节钩螺母	Nut 9/64-40	1
54	GR2626	挑线过线环	Take-up thread guide	1
55	GL48	挑线过线环螺母	Nut 9/64-40	1
56	GR3653	针杆线钩	Needle bar thread guide	1
57	GS0609	针杆线钩螺钉	Screw 11/64-40 L=8.2	1
58	GR3655	绕线器架	Bobbin winder bracket	1
59	GS0609	绕线器架螺钉	Screw 11/64-40 L=8.2	2
60	GZ468	绕线轴	Bobbin winder shaft	1
61	GW472	绕线轴弹簧	Bobbin set spring	1
62	GR3656	绕线轴挡圈	Collar	1
63	GR3657	绕线轴座	Pulley shaft base	1
64	GS0690	绕线轴座轴位螺钉	Hinge screw D=7.94 H=4.3	1
65	GL15	绕线轴座轴位螺母	Nut 15/64-28	1
66	GS0165	绕线轴座螺钉	Screw 9/64-40 L=6	3
67	GO513	绕线轴轴套	Bobbin winder shaft bushing	1
68	GR1692	绕线轮垫圈	Washer 6.5 × 11 × 1	1
69	GP178	绕线轮	Bobbin winder driving pulley	1
70	GS0181	绕线轮螺钉	Screw 3/16-28 L=7	2
71	GW473	绕线轴座扭簧	Bobbin winder spring	1
72	GS0691	绕线轴座扭簧螺钉	Hinge screw D=4.5 H=4	1
73	GR3658	满线跳板	Bobbin winder trip latch	1
74	GS0692	满线调节螺钉	Adjusting screw	1
75	GL0129	满线调节螺母	Adjusting nut	1
76	GS0693	满线跳板轴位螺钉	Hinge screw D=7.24 H2.2	1
77	GL31	满线跳板轴位螺母	Nut 11/64-40	1
78	GW474	满线跳板弹簧片	Bobbin winder trip latch spring	1
79	GS0138	弹簧片螺钉	Screw 9/64-40 L=45	2
80	GR3660	过线架	Bobbin winder tension bracket	1
81	GS0609	过线架螺钉	Screw 11/64-40 L=8.2	2
82	GR3661	过线架垫圈	Washer 4.8 × 11.5 × 2.0	2
83	GS0279	绕线过线螺钉	Bobbin winder tension post	1
84	GL31	绕线过线螺母	Nut 11/64-40	1
85	GR274-6	过线夹线板	Bobbin winder tension disc	2
86	GW15	过线夹线簧	Bobbin winder tension spring	1
87	GL112-6	过线夹线螺母	Bobbin winder tension nut	1

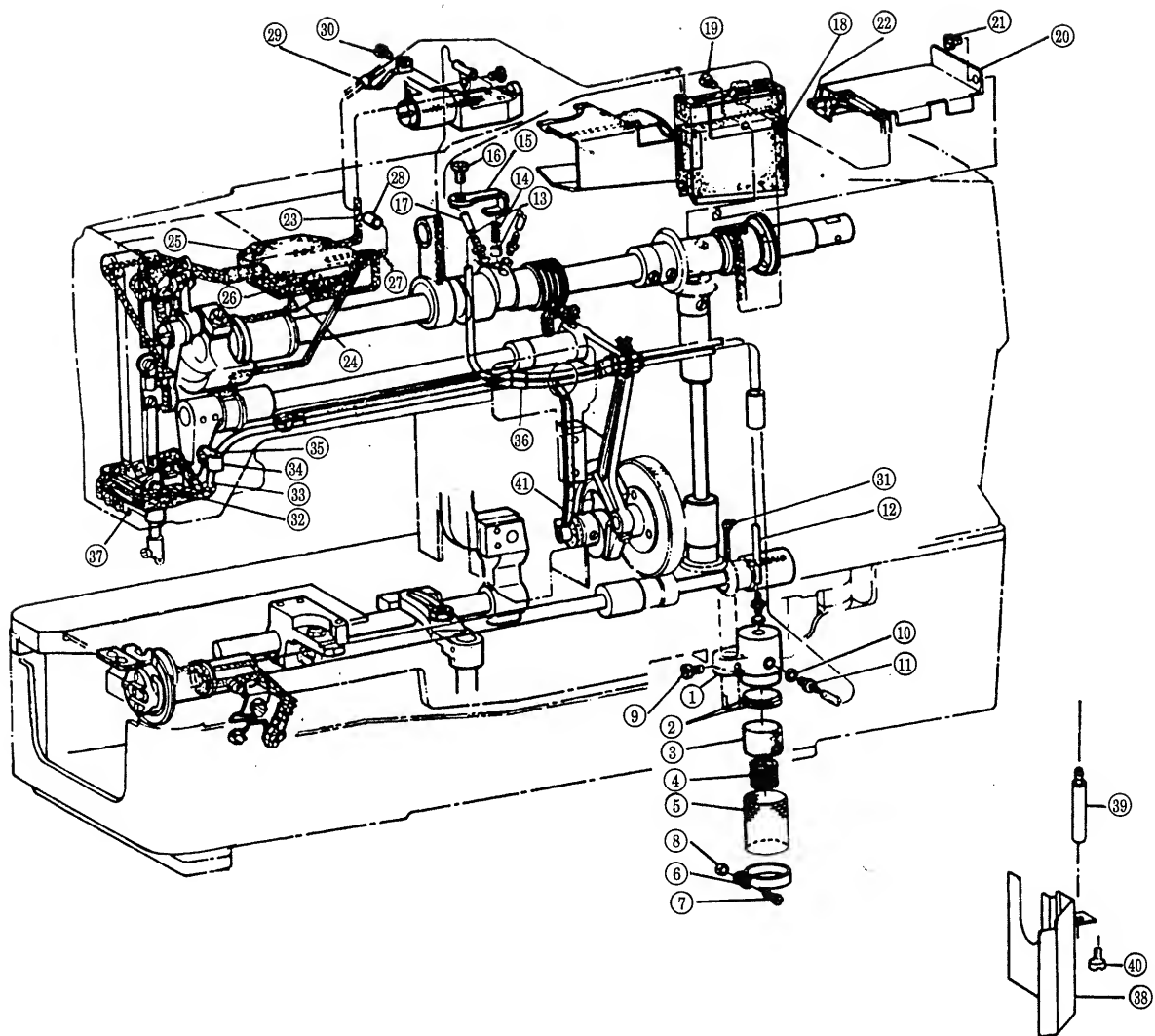


## 14、润滑系统分组件

## 14.Lubrication mechanism components

序号	件 号	名 称	数量	
Ref.No.	Part No.	Description	Amt.	
1	GR3663	油泵座 .....	Oil pump base .....	1
2	GR3664	过滤毡 .....	Filter .....	2
3	GR3665	油毡 .....	Oil felt .....	1
4	GW475	油毡压簧 .....	Spring .....	1
5	GR3666	过滤网 .....	Filter screen .....	1
6	GR3667	过滤网夹紧圈 .....	Lubricating shaft bushing holder .....	1
7	GS0100	夹紧圈螺钉 .....	Screw 9/64-40 L=8.5 .....	1
8	GL48	夹紧圈螺母 .....	Nut 9/64-40 .....	1
9	GS100	油泵座螺钉 .....	Screw 11/64-40 L=9 .....	1
10	GR3668	密封圈 .....	Gasket .....	4
11	GS0694	油管连接螺钉 .....	Connecting screw .....	4
12	GR3669	油泵座吸油管 .....	Vinyl tube white D=3 .....	1
13	GR1563	柱塞 .....	Plunger .....	1
14	GW260	柱塞簧 .....	Plunger spring .....	1
15	GR3670	柱塞簧压板 .....	Thrust plate .....	1
16	GS0213	压板螺钉 .....	Screw 15/64-28 L=7 .....	1
17	GR3671	上轴后油箱供油管 .....	Vinyl tube, white D=3 .....	1
18	GR3672/8	上轴后油箱部件 .....	Oil pan asm. ....	1
19	GS010	上轴后油箱螺钉 .....	Screw 11/64-40 L=5 .....	1
20	GK264	上轴伞齿轮罩板 .....	Oil shield .....	1
21	GS010	上轴伞齿轮罩板螺钉 .....	Screw 11/64-40 L=5 .....	1
22	GR3680	手柄伞齿轮油线 .....	Oil wick .....	1
23	GR3681	上轴前后油箱连接曲线 .....	Oil wick .....	1
24	GR3682	连接油线套管 .....	Vinyl tube, white D=6 .....	4
25	GR3683	上轴前油箱油毡 .....	Oil felt .....	2
26	GR3684	油毡垫板 .....	Groove cover .....	1
27	GR3685	上轴前轴套长油线 .....	Oil wick .....	1
28	GR3686	长油线套 .....	Vinyl tube, white D=5 .....	1
29	GR3687	长油线夹 .....	Oil felt guide .....	1
30	GS0106	长油线夹螺钉 .....	Screw 11/64-40 L=7 .....	1
31	GR3688	竖轴下轴套油线 .....	Oil wick .....	1
32	GR3689	回油除尘毡 .....	Oil return felt .....	1
33	GR3690	回油管 .....	Oil return tube .....	1
34	GR1723	回油管夹 .....	Cable holder .....	1
35	GS0106	回油管夹螺钉 .....	Screw 11/64-40 L=7 .....	1
36	GR3691	回油管导架 .....	Pipe guide .....	1
37	GR3692	回油毡压板 .....	Oil felt holder .....	1
38	GK265/2	底板挡油罩部件 .....	Bed oil shield .....	1
39	GS0695	底板挡油罩螺栓 .....	Bed oil shield stud .....	1
40	GS010	底板挡油罩螺钉 .....	Screw 11/64-40 L=5 .....	1
41	GR3694	摆动凸轮外油线 .....	Oil wick .....	1

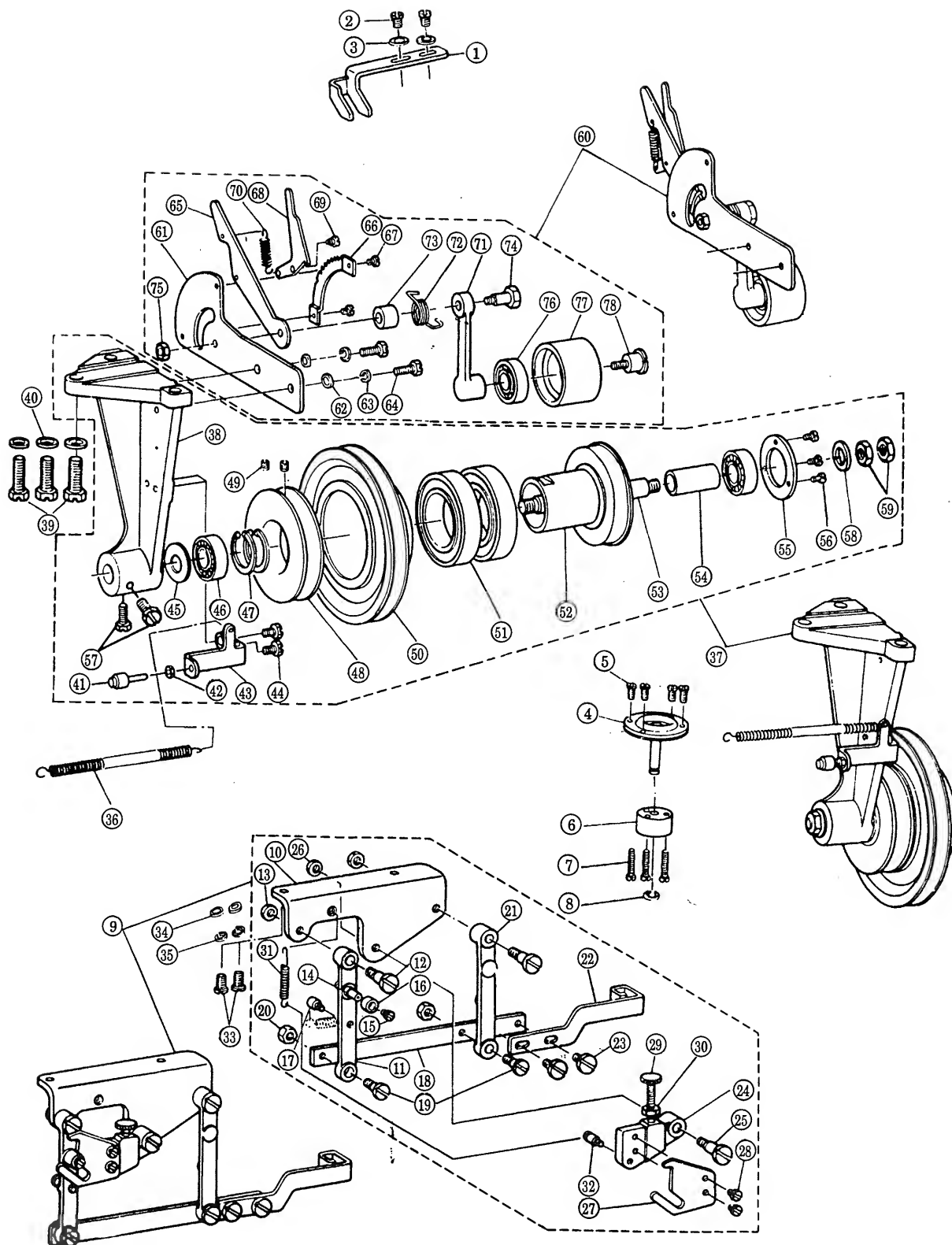




## 15、电机变速分组件

## 15.Speed transmitter components

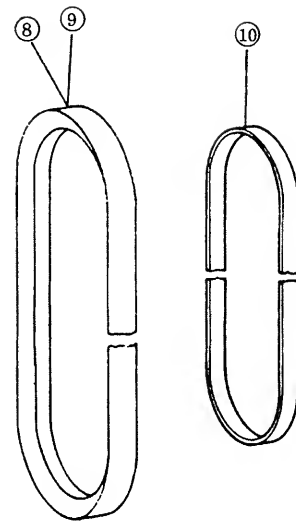
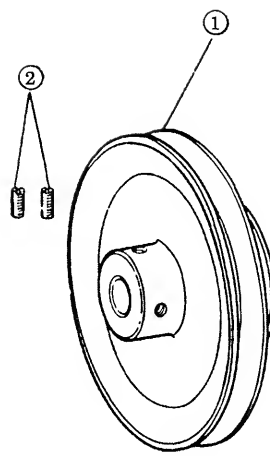
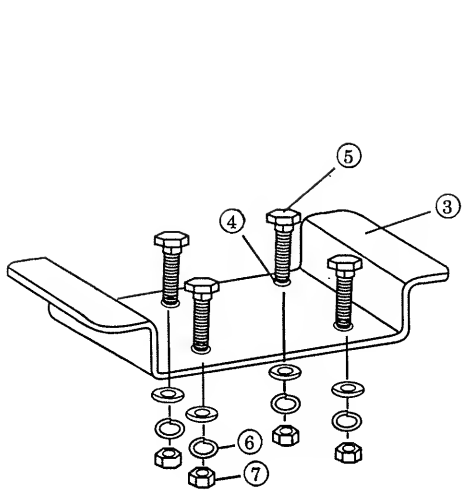
序号 Ref.No.	件 号 Part No.	名 称 Description	数量 Amt.
1	GR3695	皮带变速拨叉.....	1
2	GS091	皮带变速拨叉螺钉.....	2
3	GR2593	皮带变速拨叉螺钉垫圈.....	2
4	GH624/3	变速拨叉顶杆部件.....	1
5	GS100	防油罩螺钉.....	4
6	GR3697	拨叉顶杆座.....	1
7	GS0696	拨叉顶杆座螺钉.....	3
8	GR1507	拨叉顶杆挡圈.....	1
9	GR3698/36	变速拨叉部件.....	1
10	GR3699	拨叉底座.....	1
11	GH625	拨叉传动杆.....	1
12	GS0697	拨叉传动杆轴位螺钉.....	2
13	GL15	拨叉传动杆轴位螺母.....	2
14	GX614	滚柱销.....	1
15	GS0698	滚柱销螺钉.....	1
16	GU215	滚柱.....	1
17	GS0699	拨叉拉簧螺钉.....	1
18	GR3700	拨叉安装板.....	1
19	GS0700	拨叉安装板轴位螺钉.....	2
20	GL4	拨叉安装板轴位螺母.....	2
21	GH626	拨叉连杆.....	1
22	GR3701	变速拨叉.....	1
23	GS0195	变速拨叉螺钉.....	2
24	GR3702	拨叉槽板固定架.....	1
25	GS0697	固定架轴位螺钉.....	1
26	GL15	固定架轴位螺母.....	1
27	GR3703	拨叉槽板.....	1
28	GS100	拨叉槽板螺钉.....	2
29	GS0701	拨叉顶杆限位螺钉.....	1
30	GL21	拨叉顶杆限位螺母.....	1
31	GW476	拨叉槽板固定架拉簧.....	1
32	GS0702	固定架拉簧螺钉.....	1
33	GS091	变速拨叉底座螺钉.....	2
34	GR1599	变速拨叉底座垫圈.....	2
35	GR1630	变速拨叉底座弹簧垫圈.....	2
36	GW477	变速拨叉拉簧.....	1
37	GP174/35	变速皮带轮部件.....	1
38	GR3704	变速皮带轮座.....	1
39	GS0590	皮带轮座螺钉.....	3
40	GR1630	皮带轮弹簧垫圈.....	3
41	GS0679	变速拨叉限位螺钉部件.....	1
42	GL15	变速拨叉限位螺母.....	1
43	GR3705	变速拨叉限位架.....	1
44	GS0703	限位架螺钉.....	2
45	GR3706	增速带轮垫圈.....	1
46	GO514	带轮轴承.....	2
47	GR3707	轴承挡圈.....	2
48	GP175	增速带轮.....	1
49	GS48	增速带轮螺钉.....	2
50	GP176	低速带轮.....	1
51	GO515	低速带轮轴承.....	2
52	GP177	高速带轮.....	1
53	GZ469	变速带轮轴.....	1
54	GO516	变速带轮轴轴套.....	1
55	GK269	带轮轴承盖.....	1
56	GS0637	带轮轴承盖螺钉.....	3
57	GS0704	变速带轮轴螺钉.....	2
58	GR1451	变速带轮轴垫圈.....	1
59	GL8	变速带轮轴螺母.....	2
60	GP178/22	皮带压紧轮部件.....	1
61	GR3708	皮带压紧轮座.....	1
62	GR1599	压紧轮座垫圈.....	2
63	GR1630	压紧轮座弹簧垫圈.....	2
64	GS0703	压紧轮座螺钉.....	2
65	GH627	压紧轮摆杆.....	1
66	GR3709	压紧轮定位板.....	1
67	GS0106	压紧轮定位板螺钉.....	2
68	GR3710	压紧轮摆杆.....	1
69	GS0705	锁紧板定位螺钉.....	1
70	GW478	锁紧板拉簧.....	1
71	GH628	压紧轮连杆.....	1
72	GW479	压紧轮连杆扭簧.....	1
73	GO517	压紧轮连杆轴套.....	1
74	GS0706	压紧轮连杆轴位螺钉.....	1
75	GL21	压紧轮连杆轴位螺母.....	1
76	GO514	压紧轮轴承.....	1
77	GP179	压紧轮.....	1
78	GS0707	压紧轮轴位螺钉.....	1



## 16、电器组件

序号	件号	名称	数量
Ref.No.	Part No.	Description	Amt.
1	*GD370	电机带轮(50HZ.2600S.PM)..... Motor pulley .....	1
	GD370H	电机带轮(50HZ.3000S.PM)..... Motor pulley .....	1
	*GD370L	电机带轮(60HZ.2600S.PM)..... Motor pulley .....	1
	GD370HH	电机带轮(60HZ.3000S.PM)..... Motor pulley .....	1
2	GS48	电机带轮螺钉..... Screw .....	2
3	GD371	电机安装座..... Motor base plate .....	1
4	GD373	垫圈..... Washer .....	8
5	GL163-1	螺钉..... Mounting bolt .....	4
6	GD373-1	弹性垫圈..... Spring washer .....	4
7	GL170	螺母..... Nut M8.....	4
8	GE137	电机传动带..... V-belt .....	1
9	GE136	电机传动带(50HZ.3000S.PM)..... V-belt .....	1
	*GE137	电机传动带(50HZ.2600S.PM)..... V-belt .....	1
	*GE137L	电机传动带(60HZ.2600S.PM)..... V-belt .....	1
	GE137H	电机传动带(60HZ.3000S.PM)..... V-belt .....	1
10	GE138	机头传动带..... Belt .....	1

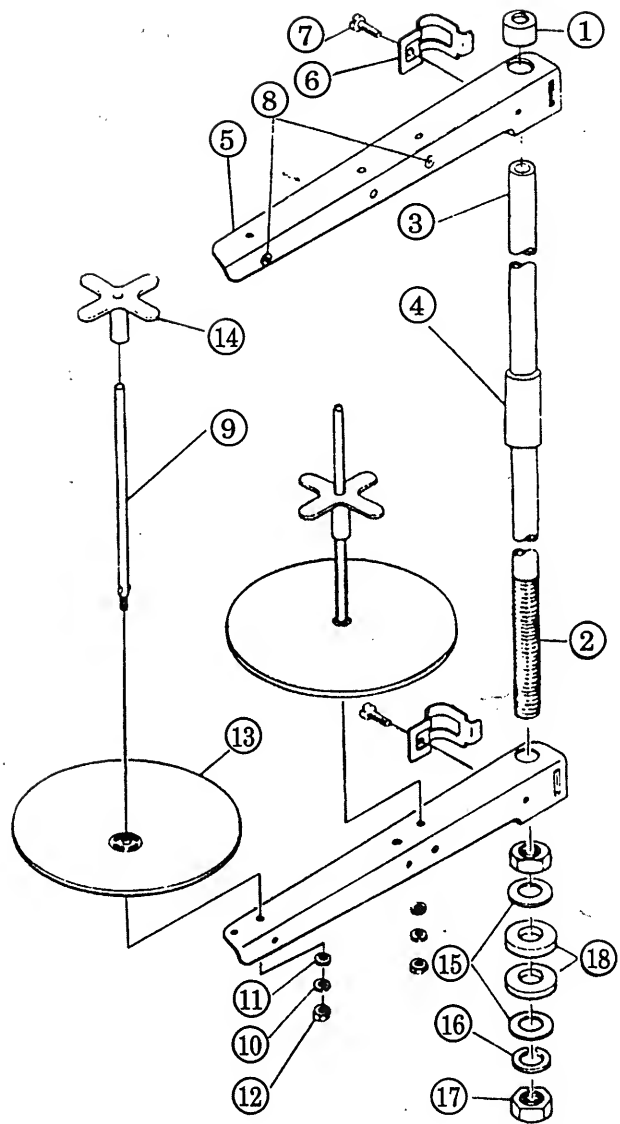
\*记号为标准配件



## 17、机头附件

## 17、Machine head accessories

序号	件 号	名 称	数量
Ref.No.	Part No.	Description	Amt.
1	GR1744	线架杆顶防护橡皮····· Spool rest rod rubber cap ·····	1
2	GZ315	线架杆下节····· Spool rest rod (lower) ·····	1
3	GZ316	线架杆上节····· Spool rest rod (upper) ·····	1
4	GR1932	线架杆接头····· Spool rested joint ·····	1
5	GR1825	线架过线杆····· Thread guide asm. ·····	2
6	GR1745	线架过线夹····· Thread guide joint ·····	2
7	GS558	线架过线夹螺钉····· Screw ·····	2
8	GR1748	过线圈····· Thread guide ring ·····	2
9	GS067	线盘钉····· Spool pin ·····	2
10	GR1625	线盘钉弹簧垫圈····· Spring washer ·····	2
11	GR1626	线盘钉垫圈····· Washer ·····	2
12	GL23	线盘钉螺母····· Nut ·····	2
13	GR1811	线盘····· Spool rest ·····	2
14	GR1215	线团防松垫····· Spool vibration stopper ·····	2
15	GR1696	线架杆紧固螺母垫圈····· Washer ·····	2
16	GR1751	线架螺母弹簧垫圈····· Spring washer ·····	1
17	GL158	线架杆紧固螺母····· Nut ·····	2
18	GR1753	线架杆防震橡皮圈····· Rubber washer ·····	2



## 18、安全板部件

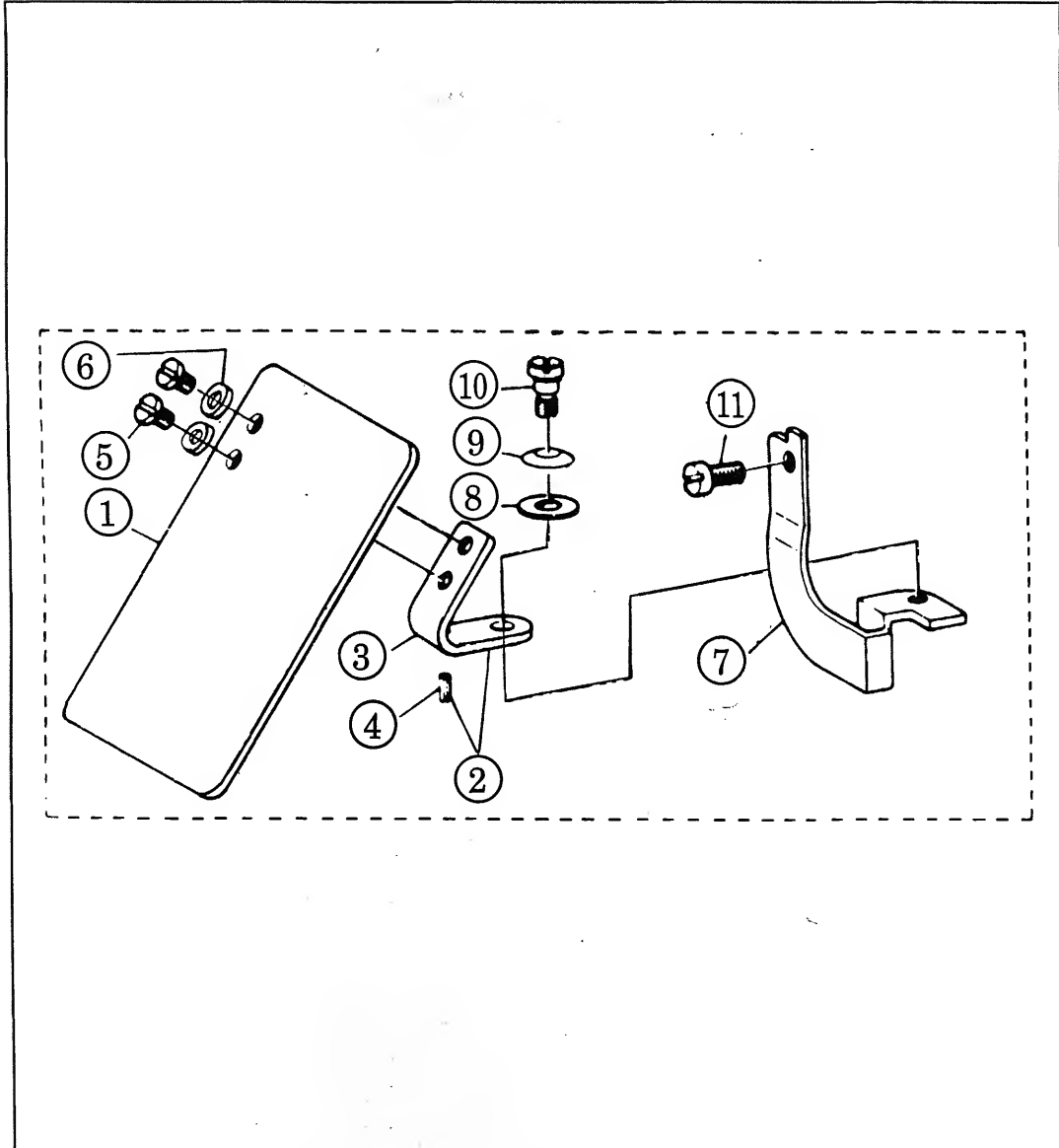
序号 件 号 名 称

## 18、Needle safety plate components

数量

Ref.No.	Part No.	Description	Amt.
1	GR2642	安全板····· Safety plate·····	1
2	GR3713/2	安全板连接架分部件····· Safety plate installing plate asm·····	1
3	GR3714	安全板连接架····· Safety plate installing plate·····	1
4	GX451	安全板连接架定位销····· Stopper pin·····	1
5	GS092	安全板连接架螺钉····· Screw 11/64-40L = 7·····	2
6	GR385	安全板连接架螺钉垫圈····· Washer·····	2
7	GR3715	安全板连接架座····· Safety plate adjusting base·····	1
8	GR2593	连接架座垫圈····· Washer 6.5×13×0.8·····	1
9	GR3453	连接架座球面垫圈····· Disc spring·····	1
10	GS098	连接架座连接螺钉····· Hinge screw·····	1
11	GS037	连接架座螺钉····· Screw·····	1





# 19、1371A附件单

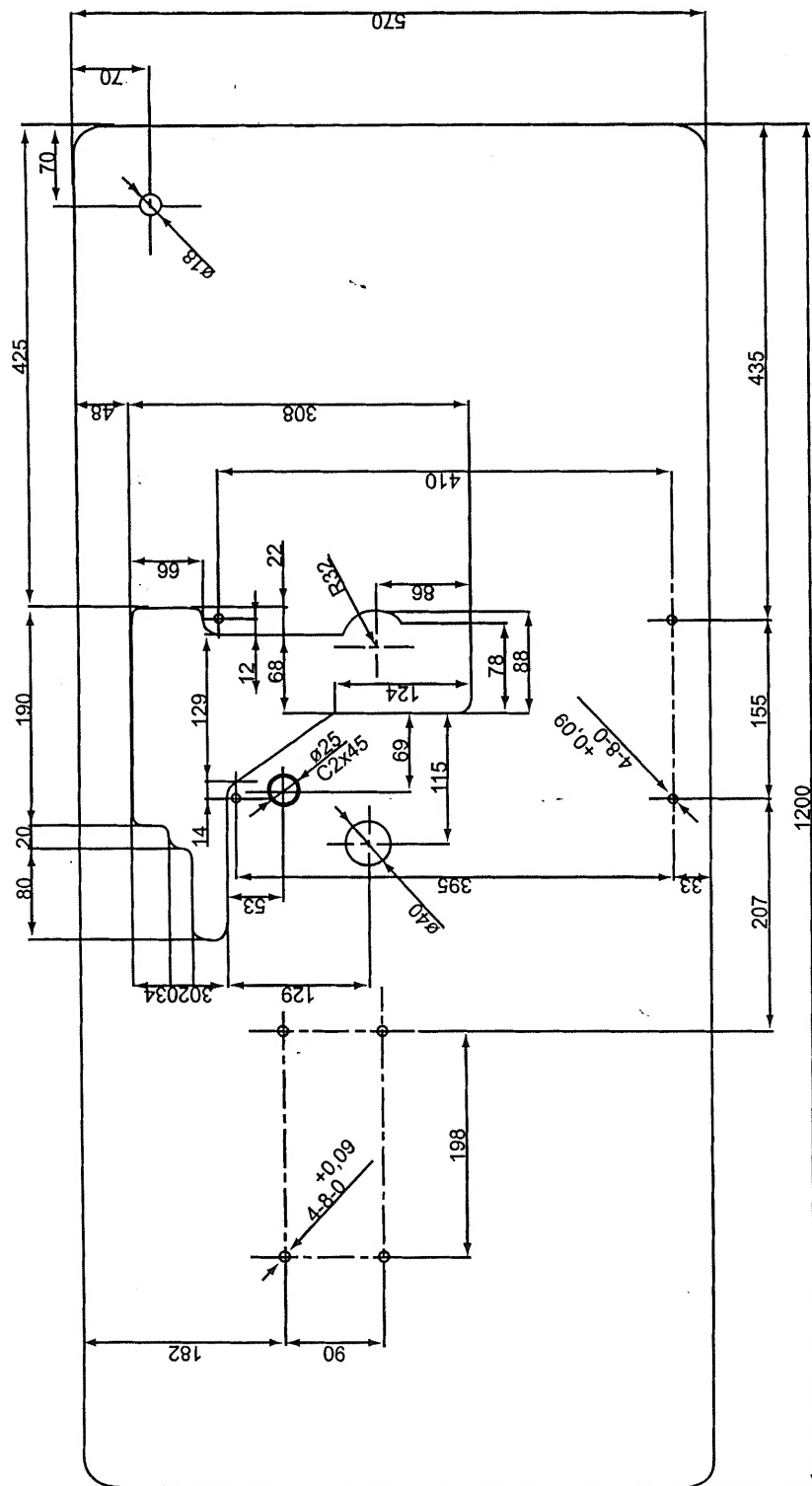
# 19 Accessories

序号	件 号	名 称	数量
Ref.No.	Part No.	Description	Amt.
1	GR1603	3x50一字螺丝批.....Screw driver 3 x 50.....	1
2	GR1602	5x75一字螺丝批.....Screw driver 5 x 75.....	1
3	GR1601	6x200一字螺丝批.....Screw driver 6 x 200.....	1
4	GR749	3MM内六角扳手.....Allen wrench 3MM.....	1
5	GR2812	4MM内六角扳手.....Allen wrench 4MM.....	1
6	GR2814/F	8--10双头扳手.....Double-head wrench 8&10.....	1
7	GR2814/G	9--11双头扳手.....Double-head wrench 9&11.....	1
8	GR2815/F	12--14双头扳手.....Double-head wrench 12&14.....	1
9	GR3716	弯把套筒扳手.....Box wrench.....	1
10	GR3711/6	交换套筒扳手.....Gear box.....	1
11	GR445/2	油壶.....Oiler.....	1
12	GN202	梭心.....Bobbin.....	4
13	GR1425	定位样板尺.....Timing gauge.....	1
14	GR3598	1/2"刀片.....Knife 1/2".....	1
15	GR3598/F	3/8"刀片.....Knife 3/8".....	1
16	GR3599	5/8"刀片.....Knife 5/8".....	1
17	GR3599/F	7/8"刀片(1371A2; 1371A3).....Knife 7/8"(1371A2;1371A3).....	1
18	GR3599/G	1"刀片(1371A2; 1371A3).....Knife 1"(1371A2;1371A3).....	1
19	GR3599/H	1-1/4"刀片(1371A3).....Knife 1-1/4"(1371A3).....	1
20	N1955-01	机针(#12).....Needle(#12).....	3

21. MKR 152/14 Extra Pedal (1 set)

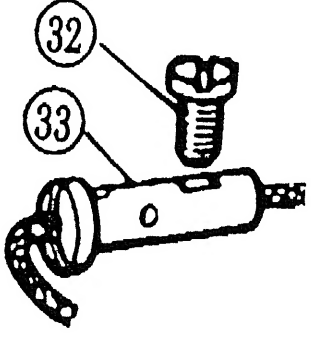
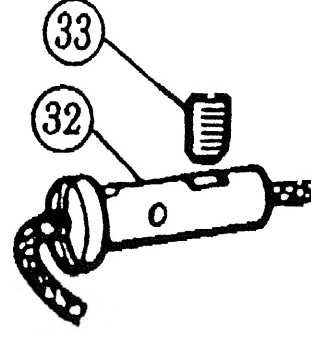
22. GE116/3 Chain + Hook (2 sets)

			42
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Unless otherwise specified all radius to be R10

## Correction

Page	Ref. No.	From	To
Page 47	32		
Page 47	33	GS05	GS04
Page 55	49	GS0106	GS013
Page 61	21	Add	GKR152/14 Extra Pedal (1 Set)
Page 61	22	Add	GE116/3 Chain & Hook (2 Sets)



Part No.IMS001-001(0502)  
Printed in China